

CARBO F-210

Standards	DIN 8555	MF7-GF-200-KNP
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Characteristics The flux-cored wire electrode is suitable for welding parts of manganese steel, which are exposed to high impact wear and tear. The non-magnetic austenitic deposit is tough, crack-free and work hardening. Typical applications can be found in the rebuilding of crusher jaws, railroad components, bucket teeth and lips, and it is designed for reclaiming worn parts of manganese base material.

Typical applications Crushers, swing hammers, railway crossings, dredger buckets

Mechanical properties of all-weld metal (typical values)	Hardness HB	Hardness after strain hardening HB
	approx. 200	approx. 420

Weld metal analysis (typical, wt. %)	C	Si	Mn	Ni
	0,30	0,4	13,0	3

Gas types EN 439 I1, M13: Argon and 99% Argon for 1% Oxygen

Current = +

Current intensity	Diameter	Volt	Ampere	Delivering form	
	1,6	20 – 26	160 – 260	O	G
	2,0	22 – 27	240 – 280	O	G
	2,4	24 – 28	280 – 340	O	G S
	2,8	25 – 29	320 – 400	O	S

Delivering form
O = Flux cored wire self shielding
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150/300 kg

Rev. 000

Statements on composition and application are just for the applicier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applicier to check our products for their special application autonomously.