

Standards

DIN 8555	MF 21-GF-65-GZ
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Characteristics CARBO F- DURIT is a tubular wire containing fused tungsten carbides for extreme wear resistant hardfacings. The weld metal is composed of fused tungsten carbides which are embedded in a hard matrix alloy.
CARBO F- DURIT is easy to use and has little spatter and smoke. It should be welded in max. 2 layers using lowest possible Amp and Volts.

Typical applications Hardfacing equipment parts which are subject to strong abrasive wear with little impact.
On parts such as mixer blades, moulding sand preparation plants, augers, scrapers etc.

Recommendations for best welding results Thoroughly clean the welding zone. It should be exempt from grease, scale, corrosion, and similar contamination.
Preheat the work piece to 300 - 500° C. During the welding process the local base material temperature has to be increased to 650°C, however, overheating should be avoided.

Hardness

Fused tungsten carbide HV	1.layer HRc	2.layer HRc
> 2300	64	66

(typical values)

Weld metal analysis (typical, wt. %)

Fe - Matrix	WSC
40	60

Gas types EN 439 M13: 99% Argon with 1% Oxygen

Current = +

Current intensity

DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	120 - 160	G
1,6	1/16	18 - 20	150 - 180	G
2,0	5/64	21 - 23	200 - 230	G
2,4	3/32	21 - 23	220 - 260	G
2,8	7/64	23 - 25	240 - 280	G

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

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg

Rev. 000