CARBO F-CH 40



DIN EN 14700 T Fe1 / MF 1-GF-400-P

General characteristics

CARBO F-CH 40 is a gas shielded flux cored wire, which is developed for hardfacing of parts, subjected to metal-to-metal friction wear (adhesion) and medium to high degree impacts. Weld metal can be machinable by chip forming by means of carbide tiped tools. Interpass temperature should not exceed 250°C, during welding.

Typical applications

Suitable for hardfacing rollers, idlers, gears, sprockets, shafts, crane rollers and mine car wheels.

Weld metal analysis (typical, wt %)											
Gew-%	C 0,2	Si 0,5	Mn 0,3	Cr 2,7	Mo 0,4						

Mechanical properties of all-weld metal (typical values)				
Hardness at Rt.	400 HB			
Operating data				

Current:	=+
Gas typs EN ISO 14175:	M21

Dia (mm)	DIA (inch)	Volt	Amps	Delivering form
1,2	3/64	19 - 22	120 - 220	G *
1,6	1/16	22 - 26	160 - 260	G *

Delivering form		
0 * = gasless (open arc), G *= gas s	shielded, S * = Submerged Arc	
Coil "BS 300" = 15 kg	Coil "BS 450" = 25 kg	Drums = 300 kg

Statements on composition and application are just for the applier.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 applier to check our products for their special application autonomously.