

## 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 tipped 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 %)

	C	Si	Mn	Cr	Mo					
Gew-%	0,2	0,5	0,3	2,7	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

O \* = gasless (open arc), G \* = gas shielded, S \* = Submerged Arc

Coil "BS 300" = 15 kg

Coil "BS 450" = 25 kg

Drums = 300 kg