

CARBO D 600B

Standards

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| DIN 8555 | E 6- UM - 60 GP |
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Approvals ---

Characteristics CARBO D 600B is a basic coated high efficiency electrode with 130 % recovery for hardfacing by applying tough-hard and abrasion-proof layers Suitable for hardfacing on machine components made of engineering steel, cast steel and manganese steel.
Smooth, intense fusion, fine-scaled seam, and easy slag removal.
The pure weld deposit is only machinable by grinding.
The electrode has a soft but intensive welding character, a fine-structured seam surface and excellent slag-removal properties.
Suitable for hardfacing on machine components made of engineering steel, cast steel and manganese steel.
Smooth, intense fusion, fine-scaled seam, and easy slag removal. The deposit can only be machined by grinding.

Welding instructions Guide electrode almost vertically with a short arc
Highly carburized or crack-sensitive base materials should be preheated to 200° – 300° C. On highly crack-sensitive base materials and manganese steel, a buffer layer of CARBO 4370 MPR or CARBODUR MnCr is recommended.

Typical applications Rollers, caterpillar tracks, track wheels, running surfaces, chaser mills, cams, paving breakers, baffles, dredger parts, rolling crushers, etc.

Operating temperature

| Hardness and recommendations for heat treatment | HRC as welded | Annealing: 5 h | Hardening oil - air |
|---|---------------|----------------|---------------------|
| | ca. 59 | 780°C – 820° C | 1000°C – 1050° C |

| Weld metal analysis (typical. wt %) | C | Cr | Mo | V |
|-------------------------------------|-----|----|-----|-----|
| | 0,6 | 9 | 0,5 | 1,4 |

Current = + / partly ~ / 42 V

Welding positions PA. PB. PC. PD. PE

Rebaking 1 h. 200 °C + (if required)

Flux-cored wire equivalent

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| CARBO F- 601 |
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| Dia./Length | Amperage (A) | Pcs./ packet | Pcs./ carton | kg / 1000 | kg / packet | kg / carton |
|-------------|--------------|--------------|--------------|-----------|-------------|-------------|
| 2,5 x 350 | 50 - 80 | 227 | 909 | 22,0 | 5,0 | 20,0 |
| 3,2 x 450 | 70 - 110 | 126 | 503 | 47,7 | 6,0 | 24,0 |
| 4,0 x 450 | 100 - 150 | 83 | 332 | 72,3 | 6,0 | 24,0 |
| 5,0 x 450 | 140 - 190 | 53 | 213 | 112,9 | 6,0 | 24,0 |
| 6,0 x 450 | 170 - 230 | 37 | 148 | 162,6 | 6,0 | 24,0 |