

CARVER 9850

FEATURES

CARVER 9850 is heavy coated electrode with excellent welding characteristics. The deposit is resistant to corrosion and oxidation and is free from cracks and porosity. The deposits resist deformation under static or cyclic loads at high temperature.

APPLICATIONS

Fabrication and repair of hot pressing tools as well as surfacing of parts subject to abrasion, oxidation and corrosion. Drop-forged dies, hot trimming dies, pump impellers, valves. Ideal for crack-free welding of parts subject to thermal and chemical influence, i.e. for the joining of heating elements.

PROCEDURE

Use either AC or DC, reverse polarity. Clean welding area. Use short arc and low currents. Cool slowly.

TECHNICAL DATA

Alloy Type	:	Ni, Cr, Mo, W, Fe Alloy
Tensile Strength	:	700 N/mm ²
Elongation	:	25-30%
Machinability	:	Excellent on all base metals
Hardness	:	Rockwell C 25-30 (As Welded), work hardens to 40-45 RC

RECOMMENDED CURRENT RANGE

SIZE (mm)	3.15	4.00	5.00
AMPS	80-120	110-160	160-210

**JOINING AND SURFACING ELECTRODE
FOR CORROSION AND OXIDATION RESISTANCE**