CARBOLLOY 520

International standards

DIN 8555	E 23-UM-300-CKNPTZ

Approvals ---

Typical applications and characteristics

CARBOLLOY 520 is a lime basic coated high CrCoMoTiAlW alloyed nickel based electrode.
The deposit is a precipitation harden able alloy with an exceptional combination of high temperature mechanical property capabilities, forgeability an corrosion resistance.
The alloy can be used for a great number of critical high temperature applications.

Operating temperature ---

Welding instructions

To achieve a crack-free overlay, the base material should be preheated to 300 – 400°C, depending on the alloy.
Slow cooling after welding is advised.

Hardness of all-weld metal (typical values)

HB as welded	HRc work-hardened
ca. 300	ca. 39

Weld metal analysis (typical, wt. %)

C	Cr	Co	Mo	Ti	Al	W	Ni
0,04	19	12	5,5	3	1	1	Rest

Current = +

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 350 °C +/ - 10 °C (if required)

Flux-cored wire equivalent

CARBO F- loy 520

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
3,2 x 350	80 - 120	155	619	32,3	5,0	20,0
4,0 x 350	110 - 150	102	409	48,9	5,0	20,0
5,0 x 450	150 - 190	61	244	98,2	6,0	24,0

Rev. 000