

Classifications

EN 14700	DIN 8555	ASME IIC SFA 5.21
T Co1	MF 20-GF-300-CTZ	ERC CoCr-E

Characteristics and typical fields of application

Cobalt base alloy providing excellent resistance to metal-to-metal wear, thermal shocks, oxidation in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode.

Microstructure: Cr and Mo carbides in an austenitic matrix

Machinability: Good

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Welding flux (for dia. 2,4): RECORD SA

Field of use Extrusion dies, hot working tools, turbine injectors, valve seats, ingot tong bits.

Typical analysis

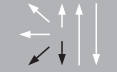
	C	Si	Mn	Cr	Ni	Mo	Co	Fe
wt.-%	0.23	1.2	1.4	27.4	2.5	4.8	bal.	2.8

Hardness as welded: 32 HRC

Mechanical properties of all-weld metal - typical values (min. values)

Condition	Hardness
	HRC
u	32
u untreated, as-welded	

Operating data

	Polarity	DC +	Dimension mm	Current A	Voltage V
	Shielding gas (EN ISO 14175)	M13: Argon 98% + Oxygen 2% / I1: Argon 100%			
	Stick-Out	max. 20 mm	1.2	110 – 180	20 – 31
			1.6	150 – 250	20 – 31
			2.4	300 – 400	20 – 31

Approvals

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