



# Selectarc Co12

“Grade 12” type cobalt base  
Hardfacing Electrode

## Description & Applications

Hardfacing electrode with a rutile-basic coating. Cobalt base deposit of « stellite grade 12 » type (Co-Cr-W). The deposit with a high hardness is characterised by a very good resistance to metal and mineral abrasion combined with corrosion and high temperature up to 800°C, in the presence of moderate shocks. Highly resistant to erosion and cavitation. Highly recommended when an important hardness is searched and for a deposit stressed by temperature, corrosion, abrasion and impact. Excellent welding characteristics.

**General application:** Hardfacing of tools for processing plastics, for wood and paper (carton and paper cutting) characteristics, pressing tools, hot cut tools , hot shear blades, extrusion screws, ...

\* Note : "Stellite" is a trade mark of Deloro Stellite (Haynes International).

## All Weld Metal Mechanical Properties

Hardness (as welded) +20°C  
~ 50 HRC

Hardness (as welded) +600°C  
38-40 HRC

## Welding Current & Instructions

Electrode	ØxL ( mm )	3,2x350	4,0x350	5,0x450
Current	( A )	100	140	180

Redrying 1h at 250°C, if necessary. Preheat massive pieces 250-400°C. Use a low current in order to limit the dilution with the base metal and to conserve the hardness of this alloy. Cool down slowly in order to limit the risk of cracks in the deposit. Weld eventual cushion layers with Selectarc 307 R.

ind.13



= +	~ 70V
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