



## FCW CO12

### Metal Cored Wire

#### Classification

AWS A5.21 : ERC CoCr-B  
EN 14700 : T Co3

DIN 8555 : MSG 20-GF-50-CTZ

#### Characteristics

Metal cored Cobalt base wire to weld with shielding gas protection with a 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.

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

#### Applications

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, ...

#### Typical Weld Metal Composition (%)

C	Si	Mn	Cr	W	Fe	Co
1.60	1.00	1.50	29.00	8.00	3.00	base

#### All Weld Metal Mechanical Properties (Typical)

Hardness at 20°C (HRC)		Hardness at 600°C (HB)	
AW	(Pure weld metal)	AW	
46		360	

#### Welding Current & Instructions

Welding Mode	Ø Wire (mm)	Welding Mode			Shielding Gas
		Current (A)	Voltage (V)	Stick-out (mm)	ISO 14175
MCAW = +	1.2	120 - 240	20 - 30	~ 25	I 1 (Ar) or M 13 (Ar + 1-2% O <sub>2</sub> ) 18 - 20 l/min
	1.6	180 - 300	20 - 30	~ 25	

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