



FCW CO21

Metal Cored Wire

Classification

AWS A5.21 : ERC CoCr-E
EN 14700 : T Co1

DIN 8555 : MSG 20-GF-350-CKTZ

Characteristics

Metal cored Cobalt base wire to weld with shielding gas protection with a Cobalt base deposit of stellite grade 21* type (Co-Cr-Mo-Ni). Deposit characterised by a good metal-metal wear and oxidation resistance up to 1000°C, even in presence of sulphurous atmosphere. Good behaviour to important thermal and mechanical shocks, excellent resistance to cracks, highly resistant to cavitation and erosion, deposit non-magnetic.

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

Applications

Surfacing of Motor Valves, Gas turbine blades, Extrusion nozzles, Forging dies, Forging tools, Mixers, Valves for gas/water/vapour/acids.

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe	Co
0.250	1.00	1.00	28.50	3.00	5.50	4.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness at 20°C (HRC)	Hardness at 20°C (HRC)	Hardness at 600°C (HRC)
AW	WH	AW
33	47	200

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 ₂) 18 - 20 l/min
	1.6	180 - 300	20 - 30	~ 25	

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