



TIG CO1

Classification

AWS A5.21 : ERCoCr-C EN 14700 : S Co3
 DIN 8555 : WSG-20-GO-55-CSTZ

Description & Applications

Cobalt Base continues cast hardfacing rod for TIG and oxy-acetylene welding. Very good resistance to metal-metal wear, abrasion and corrosion and heat up to 900°C. Excellent gliding characteristics, good to polish. Only machinable with tungsten carbide tools or by grinding.

Main applications: Cutting tools, shredding tools, mixing and drilling tools, hot working tools without thermal shock, extrusion screws.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	W	Mo	Fe	P	S	Co
2.4	1.2	0.2	31.0	2.2	12.5	0.3	2.5	<0.02	<0.03	Rem.

All Weld Metal Mechanical Properties

Hardness
 53-57 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	Ar : 6-12 l/min

Preheat large components or special steels to 500-600°C. Keep this temperature during welding and cool down slowly, preferable in an oven, to reduce the risk of cracking while cooling.
 For oxy-acetylene welding use a reducing flame (slight excess of acetylene).

ind.10



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