



# TIG CO12

## Classification

AWS A5.21 : ERCoCr-B                      EN 14700 : S Co2  
DIN 8555 : WSG-20-GO-50-CSTZ

## Description & Applications

Cobalt Base continues cast hardfacing rod for TIG and oxy-acetylene welding. Very good resistance to metal-metal wear, abrasion, cavitation, 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, saw blades, extrusion dies, mixing tools, hot working tools without thermal shock, extrusion screws in the wood, paper and plastic industry.

## Typical Chemical Composition ( % )

C	Si	Mn	Cr	Ni	Mo	W	Fe	P	S	Co
1.4	1.4	0.1	30.5	2.4	0.2	8.4	2.0	<0.02	<0.03	Rem.

## All Weld Metal Mechanical Properties

Hardness  
47-50 HRC

## Welding Current & Instructions

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

Preheat large components or special steels to 400-600°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).

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