



TIG CO190

Classification

AWS A5.21 : ERCoCr-G

EN 14700 : S Z Co3

Description & Applications

Cobalt base solid rod for TIG harfacing of Cobalt alloy with similar chemical composition. Excellent abrasion resistance under high load.

Main applications: Hardfacing of tri-cone drilling tools...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S	A/T	Co
Min	3.0			24				12				
Max	4.0	2.0	1.0	30	4.0	1.0	3.0	16	0.03	0.03	0.50	Rem.
Type	3.4	1.0	0.30	27.0	0.60	0.01	2.0	13.6	0.01	0.01	<0.50	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)

54-57 HRC

Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 L/min

FT En-TC03-17

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