



TIG FICO25

Classification

DIN 8555 : WSG 20-GZ-250-CKTZ Material N° : 2.4964
EN 14700 : S Z Co1 AMS : 5796

Description & Applications

Cobalt Base continues cast hardfacing rod for TIG welding. Very good resistance to metal-metal wear, thermal shock and corrosion up to 1000°C even in sulphuric gases. Non magnetic deposit.

Main applications: Engine valves, forging dies, gas turbines, mixers.

Base materials: Alloy 25, UNS R30605, AMS 5537, Material N° 2.4964, CoCr20W15Ni and similar.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	W	Fe	P	S	Co
0.1	0.1	1.5	20.0	10.0	15.0	<1.0	<0.01	<0.01	Rem.

All Weld Metal Mechanical Properties

Hardness
~230 HB

Welding Current & Instructions

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

ind.10



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