

Classifications

AWS A5.21 / SFA-5.21
EN 14700

ER CoCr-C

Co3

Characteristics and typical fields of application

UTP A CELSIT 701 N is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, corrosion and high heat up to 900° C, such as working parts in the chemical industry, running and sealing faces of fittings, valve seats and cones for combustion engines, cutting and shredding tools, heavyduty hot working tools without thermal shock, milling, mixing and drilling tools. Excellent gliding characteristics, good polishability, slightly magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of the pure weld deposit: 54 - 56 HRC
 at 600°C ca. 42 HRC
 at 800°C ca. 34 HRC

Typical analysis

	C	Cr	W	Co
wt.-%	2.3	32	13	Bal.

Operating data

Polarity	DC –	Dimension mm
Shielding gas (EN ISO 14175)	I 1	3.2 × 1000
		4.0 × 1000

Clean weld area. Preheating temperature 500 – 600° C, very slow cooling.
 Reduce excess of acetylene (reduced fl ame) in oxyacetylene welding.

Approvals

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