

Meltolit

Co1 MCW

AWS A 5.21: ERCCoCr-C
EN 14700 Co3

DESCRIPTION

Cobalt base tubular wire for gas shielded metal arc hardfacing. Exceptional resistance to metal-to-metal wear in corrosive media at high temperatures, where impacts are low to moderate. Structure: chromium and tungsten carbides in an austenitic type matrix. Applications: Steam valves, wire guides, rubber and plastic mixers, extrusion screws, conveyors etc.

WELDING POSITIONS



CURRENT TYPE

DC(+) /pulsed

GAS

EN ISO 14175: I1(Ar)

MECHANICAL PROPERTIES

Hardness

As welded 53 HRC
600°C 44 HRC
800°C 34 HRC

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	W	Fe	Co	
2,3	1,0	1,0	29,0	12,0	4,0	Rest	

PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6
Spool(kg)	15	15
Stick-out(mm)	15-30 (optimum 25)	15-30 (optimum 25)
Amperage(A)	100-250 (optimum 200)	140-350 (optimum 250)
Voltage(V)	16-29 (optimum 28)	16-30 (optimum 28)
Gas flow(l/min)	10-20	10-20

EQUIVALENT CONSUMABLES

MMA	Meltolit Co1 E
TIG	Meltolit Co1 Tig