



Co12 MCW

AWS A 5.21: ERCCoCr-E
EN 14700 TCo2

DESCRIPTION

Cobalt base tubular wire for gas shielded metal arc hardfacing. Exceptional resistance to metal-to-metal wear in corrosive media at high temperatures.

Structure: chromium and tungsten carbides in an austenitic type matrix.

Applications: Saw teeth, cams, shafts, cutting edges and other tools in wood, plastic, paper, carpet and chemical industry.

WELDING POSITIONS



CURRENT TYPE

DC(+) /pulsed

GAS

EN ISO 14175: I1(Ar)

MECHANICAL PROPERTIES

Hardness

As welded 46 HRC

300°C 37 HRC, 600°C 32 HRC

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	W	Fe	Co	
1,6	1,0	1,5	29,0	8,0	3,0	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 Co12 E
TIG	Meltolit Co12 Tig