



Co21 MCW

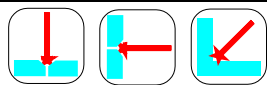
AWS A 5.21: ERCCoCr-E
EN 14700 TCo1

DESCRIPTION

Cobalt base tubular wire for gas shielded metal arc hardfacing. Excellent resistance to metal-to-metal wear combined with good corrosion resistance and high temperatures up to 900°C. Less crack sensitive than other cobalt base alloys and highest corrosion and thermal shock resistance. Machinable.

Applications: Components exposed to high temperatures, corrosion and impact stress such as valve seats and components in chemical industry.

WELDING POSITIONS



CURRENT TYPE

DC(+) /pulsed

GAS

EN ISO 14175: I1(Ar)

MECHANICAL PROPERTIES

Hardness

As welded 33 HRC
Work hardening to 47 HRC

TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	Ni	Mo	Fe	Co
0,25	1,0	1,0	28,5	3,0	5,5	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 Co21 E
TIG	Meltolit Co21 Tig