

TIG Co12



Classification

AWS A5.21 : ERCoCr-B AFNOR : KC 29 W9
DIN 8555 : WSG-20-GO-50-CSTZ

Description & Applications

Cobalt Base continues cast hardfacing rod for GTAW / TIG and OAW / oxy-acetylene welding.
Very good resistance to metal-metal wear ,abrasion , cavitation, corrosion and heat up to 900°C.
Excellent gliding characteristics, good to polish.
Typical applications: Cutting tools, shredding tools, saw blades, extrusion dies, mixing tools, hot working tools without thermal shock, extrusion screws in the wood, paper and plastic industry.
Only machinable with tungsten carbide tools or by grinding.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	W	Fe	P	S	Co
1.4	1.4	0.1	30.5	2.4	0.2	8.4	2.0	<0.02	<0.03	Base

All Weld Metal Mechanical Properties

Hardness
47-50 HRC

Welding Current & Instructions

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

For oxy-acetylene welding use a reducing flame (slight excess of acetylene).

Preheat large components or special steels to 400-600°C. Keep this temperature during welding and cool down slowly, preferable in an oven, to reduce the risk of cracking while cooling.

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