

TIG Co21



Classification

AWS A5.21 : ERCoCr-E AFNOR : KC 27 D
DIN 8555 : WSG-20-GO-300-CKTZ AMS : 5385

Description & Applications

Cobalt Base continues cast hardfacing rod for GTAW / TIG welding.
Very good resistance to metal-metal wear ,thermal shock, corrosion and heat up to 1000°C.
Excellent gliding characteristics, high toughness, good to polish, non-magnetic.
Typical applications: Engine valves, hot forging dies, gas turbines.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	W	Fe	P	S	Co
0.25	0.6	0.3	27.8	2.4	5.4	0.01	1.4	<0.02	<0.03	Base

All Weld Metal Mechanical Properties

Hardness	Hardness at 600°C
29-33 HRC	~240 HB

Welding Current & Instructions

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

Preheat large components or special steels to 200-400°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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