

TIG Co6



Classification

AWS A5.21 : ERCoCr-A AFNOR : KC 29 W5
DIN 8555 : WSG-20-GO-40-CTZ

Description & Applications

Cobalt Base continues cast hardfacing rod for GTAW / TIG and OAW / oxy-acetylene welding. Very good resistance to metal-metal wear ,cavitation and corrosion as well as heat up to 900°C. Excellent gliding characteristics, good to polish, non-magnetic.
Typical applications: Valves, valve seats and other sealing faces, hot pressing tools, pump parts, extrusion screws.
Machinable with tungsten carbide tools or by grinding.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	W	Mo	Fe	P	S	Co
1.2	1.3	0.1	29.5	2.5	4.6	0.3	2.4	<0.02	<0.03	Base

All Weld Metal Mechanical Properties

Hardness
39-43 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 300-600°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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FSH WELDING GROUP:

www.fsh-welding.com - info@fsh-welding.com