

COBASTEL FCW 6

Flux cored wires [FCAW]

Cobalt alloys

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : MF 20-GF-40-CTZ AWS A-5.13 : E CoCr-A		Hardfacing and repairing

- Flux-cored wire forming a cobalt-based deposit with an austenitic-ledeburic structure, with embedded tungsten carbides (CrW).
- The overlay is resistant to corrosion, impact, abrasion, as well as thermal shocks and high mechanical pressure.
- Resistant to adhesion mechanisms.

Welding instructions: working temperature should be kept between 400° and 600°C, depending on the base material and type of construction. For low alloyed and austenitic steels, low cooling or if necessary oven cooling is recommended.

Working temperature: from room temperature up to 600°C.

Application

Surfacing of steam and chemical valves and tools working with hot steel, such as: shear knives, pumps for high-temperature liquids etc.

Typical chemical composition %

C	Si	Mn	Cr	Fe	Co	W
1,1	1,0	0,60	28,0	<2,5	rest	4,5

Typical mechanical properties

Hardness 38-42 HRC (RT) / 35 HRC (300°C) / 29 HRC (600°C) /

Wire/rod type flux cored

Welding current



Additional description Melting range: 1350°C Density: 8,3 g/cm3

Shielding gases acc. to EN ISO 14175 M13 - Ar + 0.5 - 3% O2 /

Welding parameters and packing

Ø	Welding current [A]	Voltage [V]	Weight of packet [kg]
1,2	80-200	16-23	15,0
1,6	100-260	18-27	15,0
2,0	120-320	19-28	15,0
2,4	160-380	19-29	15,0
2,8	180-400		15,0

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