

## COBASTEL 12

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b> EN ISO 14700-A : E Co2 cpgt DIN 8555 : E 20-UM-50-CTZ AWS A-5.13 : E CoCr-B	<b>APPROVALS:</b>	<b>APPLICATION:</b> Hardfacing and repairing
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- Rutile-basic electrode with alloyed core wire for welding with alternating current.
- A cobalt-based overlay 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.
- The weld deposit is only machined with the appropriate cutting tools.
- Operating temperature: from room temperature to 600°C.

### Recommendations:

- The operating temperature should be maintained between 400° and 600°C, depending on the base material and type of construction.
- Slow cooling, and if required furnace cooling, is recommended for low alloy and austenitic steels.

### Application

Hardfacing of cutting edges, long knives and other tools used in the wood, textile, paper and chemical industries. Regeneration of saws for cutting wood.

### Typical chemical composition %

C	Si	Mn	Cr	Fe	Co	W	Inne
1,40	1,00	1,00	28,00	3,00	rest	8,50	<3,00

### Typical mechanical properties

**Hardness** 48 HRC (RT) / 37 HRC (300°C) / 32 HRC (600°C) /

**Coating type** rutile-basic

**Welding current**



**Welding positions**



**Redrying** 350°C / 1 h

**Additional description** Melting temperature: 1280 - 1320°C Density: 8,7 g3/cm3

### Welding parameters and packing

∅	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
3,2	350 /	70-110	5,0	20,0
4,0	350 /	100-140	5,0	20,0
5,0	350 /	140-180	5,0	20,0

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