## *ΜΕΤΔĹΨΕĹ*

## **COBASTEL 12**

Electrodes MMA [SMAW]

Hardfacing and repairing

| CLASSIFICATION:   |  | APPROVALS:  | APPLICATION:   |  |
|---|--|---|--|--|
| EN ISO 14700-A : E Co   | o2 cpgt  |   | Hardfacing a   | and repairing                              |
| DIN 8555 : E 20-UM-5  | 0-CTZ  |   |  |  |
| AWS A-5.13 : E CoCr-E   | 3  |   |  |  |
| <ul> <li>Rutile-basic electrode with alloyed core wire for welding with alternating current.</li> <li>A cobalt-based overlay with an austenitic-ledeburic structure with embedded tungsten carbides (CrW).</li> <li>The overlay is resistant to corrosion, impact, abrasion as well as thermal shocks and high mechanical pressure.</li> <li>The weld deposit is only machined with the appropriate cutting tools.</li> <li>Operating temperature: from room temperature to 600°C.</li> </ul> |  |   |  |  |
| Recommendations:  |  |   |  |  |
| <ul> <li>The operating temperature should be maintained between 400° and 600°C, depending on the base material and type of construction.</li> <li>Slow cooling, and if required furnace cooling, is recommended for low alloy and austenitic steels.</li> </ul>   |  |   |  |  |
| 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 %  |  |   |  |  |
|   |  |   |  |  |
| <b>C Si</b><br>1,40 1,00  | Mn         Cr           1,00         28                                    | <b>Fe Co</b><br>3,00 3,00 rest  | <b>W</b> Inne<br>8,50 <3,00                          |  |
| CSi1,401,00Typical mechanical pr  | Mn Cr<br>1,00 28<br>operties   | <b>r Fe Co</b><br>3,00 3,00 rest  | <b>W Inne</b><br>8,50 <3,00                          |  |
| CSi1,401,00Typical mechanical prHardness  | Mn Cr<br>1,00 28<br>operties   | <b>Fe Co</b><br>3,00 3,00 rest<br>48 HRC (RT) / 37 HRC (300°  | W         Inne           8,50         <3,00          |  |
| CSi1,401,00Typical mechanical prHardnessCoating type  | Mn Cr<br>1,00 28<br>operties   | Fe         Co           3,00         3,00         rest           48 HRC (RT) / 37 HRC (300°)           rutile-basic   | W         Inne           8,50         <3,00          |  |
| CSi1,401,00Typical mechanical prHardnessCoating typeWelding current   | Mn Cr<br>1,00 28<br>operties   | Fe       Co         3,00       3,00       rest         48 HRC (RT) / 37 HRC (300°)         rutile-basic         U   | W 8,50 Inne <3,00<br>C) / 32 HRC (600°C) /<br>5<50 V |  |
| CSi1,401,00Typical mechanical prHardnessCoating typeWelding currentWelding positions  | Mn Cr<br>1,00 28<br>operties   | Fe       Co         3,00       3,00       rest         48 HRC (RT) / 37 HRC (300°       rutile-basic         Image: transformed state sta | W       Inne         8,50       <3,00                |  |
| C Si<br>1,40 1,00<br>Typical mechanical pr<br>Hardness<br>Coating type<br>Welding current<br>Welding positions  | Mn Cr<br>1,00 28<br>operties   | Fe       Co         3,00       rest         48 HRC (RT) / 37 HRC (300°)         rutile-basic         Image: the state of the          | W       Inne         8,50       <3,00                |  |
| CSi1,401,00Typical mechanical prHardnessCoating typeWelding currentWelding positionsWelding positionsRedryingAdditional description   | Mn Cr<br>1,00 28<br>operties   | Fe       Co         3,00       rest         48 HRC (RT) / 37 HRC (300°)         rutile-basic         Image: Construction of the second s         | W       Inne         8,50       <3,00                | g3/cm3                                     |
| CSi1,401,00Typical mechanical prHardnessCoating typeWelding currentWelding currentWelding positionsRedryingAdditional descriptiWelding parameters a   | Mn Cr<br>1,00 28<br>operties   | Fe       Co         3,00       3,00       rest         48 HRC (RT) / 37 HRC (300%         rutile-basic         Image: training temperature: 1280 - 1  | W       Inne         8,50       <3,00                | g3/cm3                                     |
| CSi1,401,00Typical mechanical prHardnessCoating typeWelding currentWelding currentWelding positionsRedryingAdditional descriptiWelding parameters aØ  | Mn Cr<br>1,00 28<br>operties   | Fe       Co         3,00       rest         48 HRC (RT) / 37 HRC (300°)         rutile-basic         Image: Construction of the second s         | W       Inne         8,50       <3,00                | g3/cm3<br>Weight of carton<br>[kg]         |
| CSi1,401,00Typical mechanical prHardnessCoating typeWelding currentWelding currentWelding positionsRedryingAdditional descriptiWelding parameters at a statementØ3,2  | Mn Cr<br>1,00 28<br>operties<br>ion<br>ind packing<br>Length [mm]<br>350 / | Fe       Co         3,00       3,00       rest         48 HRC (RT) / 37 HRC (300°       rutile-basic         rutile-basic       U         Image:                                    | W       Inne         8,50       <3,00                | g3/cm3<br>Weight of carton<br>[kg]<br>20,0 |

140-180

5,0

20,0

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350 /

5,0

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