

# COBASTEL 21

Electrodes MMA [SMAW]

Hardfacing and repairing

<b>CLASSIFICATION:</b>	<b>APPROVALS:</b>	<b>APPLICATION:</b>
EN ISO 14700-A : E Co1 cktz DIN 8555 : E 20-UM-300-CKTZ AWS A-5.13 : E CoCr-E		Hardfacing and repairing

- AC weldable rutile electrode.
- Cobalt-based overlay with high tensile strength as well as very high corrosion resistance and high heat resistance.
- The deposit is characterized by high impact strength and can be hardened up to 45 HRC.
- For hardfacing materials exposed to corrosion, high temperatures and thermal shocks.

**Welding instructions:** The working 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.

**Operating temperature:** from room temperature to 300°C



## Application

Hardfacing of cutting edges, long knives and other tools used in the wood, textile, paper and chemical industries. Hardfacing of rolls for the production of seamless pipes.

## Typical chemical composition %

C	Si	Mn	Cr	Ni	Mo	Fe	Co	Inne
0,30	0,90	1,00	28,00	3,00	5,50	3,00	rest	<3,00

## Typical mechanical properties

<b>Hardness</b>	30 HRC (RT) / 280 HB (300°C) / 280 HB (work hardened) /
<b>Coating type</b>	rutile
<b>Welding current</b>	 $U_0 < 50V$
<b>Welding positions</b>	
<b>Redrying</b>	350°C / 1 h
<b>Additional description</b>	Melting temperature: 1250°C Density: 8,3 g/cm3

## Welding parameters and packing

Ø	Length [mm]	Welding current [A]	Weight of packet [kg]	Weight of carton [kg]
2,5	350 /	40-75	5,0	20,0
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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