

COBASTEL 25

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION: DIN 8555 : E 20-UM-300-CKTZ	APPROVALS:	APPLICATION: Hardfacing and repairing
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- AC weldable rutile electrode.
- The deposit is cobalt base alloy with 10% of nickle for matrix stabilization.
- The deposit is resistant to corrosion in high temperatures, impact, extreme thermal shocks and oxidation..

Working temperature: depending on the base materials and it's construction. Low colling is recommended for low alloyed and austenitic steels.

Operating temperature: from RT till 900°C

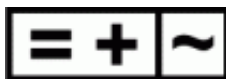

Application

Forging tools, aviation industry, blades in turbochargers, parts exposed to many factors at the same time, such as: impact, pressure, corrosion, erosion, etc. Surfacing of steam valves, as well as tools working with hot steel, such as: shear knives, high temperature fluid pumps, etc.

Typical chemical composition %

C	Si	Mn	Cr	Ni	Fe	Co	W
<0,10	0,80	1,00	20,00	10,00	<3,00	rest	15,00

Typical mechanical properties

Tensile strength Rm [N/mm2]	>630 (20°C), >300 (800°C)
Elongation A5 [%]	>5,5 (20°C), >13 (800°C)
Hardness	285 HB (RT) / 140 HB (900°C) / 45 HRC (work hardened) /
Coating type	rutile
Welding current	 U₀ < 50V
Welding positions	
Redrying	350°C / 1 h
Additional description	Melting temperature: 1280 - 1390°C Density: 8,3 g/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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