

COBASTEL 25

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
DIN 8555 : E 20-UM-300-CKTZ		Hardfacing and repairing
 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 <0,10	Ni Fe 0,00 10,00 <3,00	Co W 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	= + ~ U ₀ .	< 50 V
Welding positions		
Redrying	350°C / 1 h	
Additional description	Melting temperature: 1280 - 1390°C Density: 8,3 g/cm3	
Welding parameters and packing		
ø Length [mm]	Welding current [A]	Weight of packet [kg] Weight of carton
3,2 350 /	70-110	5,0 20,0
4,0 350 / 5.0 350 /	140-180	5,0 20,0 5,0 20,0
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