

COBASTEL 6

Electrodes MMA [SMAW]

Hardfacing and repairing

CLASSIFICATION:	APPROVALS:	APPLICATION:
EN ISO 14700-A : E Co2 ctz DIN 8555 : E 20-UM-40-CTZ AWS A-5.13 : E CoCr-A		Hardfacing and repairing

- Rutile-basic electrode with alloyed core wire suitable for welding with AC.
- The deposit is cobalt base alloy with embedded CrW carbides, the structure is austenitic-ledgeburitic.
- The deposit is resistant to corrosion, impact, abrasion and also thermal shocks and heavy mechanical impact.
- Resistant to adhesion mechanisms.
- Operating temperature: from RT till 600°C.

Recommendations:

Working temperature: 400 - 600°C, depending on the base materials and it's construction.

Low colling is recommended for low alloyed and austenitic steels.



Application

Hardfacing of steam valves, valves in thermoelectric turbines, valves made of austenitic steels, as well as tools working with hot steel, such as: shear knives, pumps for high temperature liquids, etc.

Typical chemical composition %

C	Si	Mn	Cr	Fe	Co	W	Inne
1,00	0,90	1,00	28,00	3,00	rest	4,50	<3,00

Typical mechanical properties

Hardness	42 HRC (RT) / 35 HRC (300°C) / 29 HRC (600°C) /
Coating type	rutile-basic
Welding current	 U₀ < 50V
Welding positions	
Redrying	350°C / 1 h
Additional description	Melting temperature: 1280 - 1390°C Density: 8,3 g/cm ³

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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