

Standards

TS EN 14700	: T Co2
EN 14700	: T Co2
DIN 8555	: MF 20-45-CTZ

**Chemical Composition of
Weld Metal % (Typical)**

C	Mn	Si	W	Fe	Cr	Co
1.1	0.6	1.0	4.5	<3.0	28.0	Rest

Mechanical Properties

Hardness
(As Welded) (HRC)
40 - 43

Typical Base Material Grades

- Best used on steam and chemical valves and on equipment handling hot steel, such as tong bits, hot steel shear blades, etc. Thermal shock resistant, abrasion, erosion, corrosion, cavitation at high temperature, bearing surfaces, chemical industry, hot shear blades, valves

Features and Applications

- Cobalt-based alloys with an austenitic-ledeburitic structure containing chrome and tungsten carbides
- These alloys are resistant against high corrosion and abrasion, high impact stress and extreme temperature shocks
- The deposit is machinable by hard metal tools
- Shielding Gas: M13 (Ar +1 %O₂)

Resistance Type and Level

Friction	High Temp.	Corrosive	Machining
██████████	██████████	██████████	██████████
Impact	Thermo Shock	Crack Resistance	
██████████	██████████	██████████	

Operating Data

Diameter (mm)	Welding Current (A)	Voltage (V)
1.20	140 - 200	26.0 - 32.0

Current Type

FCAW / D.C. (+)

Operating Data

Product Code	Diameter x Length (mm) / (inch)		Package Weight (Kg)
6031100191	1.20	0.047"	15

Approvals: SEPRO