

STELLOY C-S

CLASSIFICATION

EN 14700: TNi2

AWS A 5.21/ASME II C SFA 5.21: ERCNiCrMo-5A

DIN 8555¹: UP 23-GF-200/350-CKNTZ

¹ Former classification replaced by EN 14700

DESCRIPTION

- Nickel-based super-alloy flux-cored wire of the NiCrMoW type
- Particularly resistant to corrosion under oxidising and reducing atmospheres
- Weld metal is designed to withstand impact, compression, abrasion, oxidation, corrosion and heat up to 1100°C
- Excellent thermal shock resistance
- Can be machined without previous heat treatment

APPLICATIONS

STELLOY C-S is suitable for welding of joints in steel clad with a nickel-chromium-molybdenum alloy and for the joining of nickel-chromium-molybdenum alloys to steel or to other nickel base alloys.

Base materials : UNS N 10002 (ASTM B 334, B 336, B 366)

STELLOY C-S is also destined in general to surface all parts undergoing mechanical stress combined with corrosion, thermal shocks and/or high temperatures

Examples

Hot shear blades, lime kiln burner parts, dies, swages, press tools as well as pump parts, hot-piercing punches, rolling and wire-drawing guides, valves and reservoirs...

TYPICAL ALL-WELD METAL ANALYSIS with flux WAF 325

C	Mn	Si	Cr	Mo	Fe	W	Ni
0.05	0.60	0.50	16.00	16.00	5.00	4.50	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded: 200HB

Work hardened: 350HB

WAF 325 - FLUX DESCRIPTION

Classification	EN 760: S A AB 1 65 DC H5
Basicity index	2.3 (according to Boniszewski)
Granulometry	0.25 - 2.5 mm
Current	DC by preference
Redrying	2 hours at 300 - 350°C
Packaging	bags (25 kg)

STANDARD DIAMETERS (mm)

2.4

Other diameters: please consult us

PACKAGING

Diameter	< 2.4 mm		> 2.4 mm
Standard packaging [EN ISO 544]	Spool : BS 300	Coil	Drum
Weight	15 kg	25 kg	Up to 330 kg