

STELLOY CCo-G

CLASSIFICATION

EN 14700: TNi2

DIN 8555¹: MSG 23-GF-200/350-CKNTZ

¹ Former classification replaced by EN 14700

DESCRIPTION

- Cobalt hardened super-alloy metal-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 CCo-G is suitable for surfacing parts undergoing oxidation, corrosion and mechanical stresses at high temperature

Examples

Tube extrusion mandrels, hot shearing blades, extrusion tooling, forging dies.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe	W	Co	Ni
0.05	1.00	0.60	15.50	16.00	3.00	4.40	2.30	Bal.

Structure: solid solution of the austenitic type

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness -3 layers deposit on mild steel:

As welded: 220 HB
Work hardened: 350 HB

SHIELDING GAS

I1 according to EN ISO 14175 (pure Argon)

CONDITIONS OF USE

Current type	Gas flow rate	Recovery
DC(+) or pulsed	10 - 20 l/min	98%

OPERATING CONDITIONS

Diameter [mm]	Amperage [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	140 - 300	250	22 - 28	28	15 - 25	20
2.4	280 - 350	300	26 - 30	28	15 - 25	20

Recovery: 98 %

WELDING POSITIONS

EN ISO 6947: PA, PB, PC

ASME IX: 1G, 1F, 2F

STANDARD DIAMETERS (mm)

1.6, 2.4 mm

Other diameters: please consult us

PACKAGING

Diameter	2.4 mm	
Standard packaging	Spool EN ISO 544: BS 300	Coil EN ISO 544: C450
Weight	15 kg	25 kg