

STELLOY CCo-O

CLASSIFICATION

EN 14700: TNi2

DIN 8555¹: MF 23-GF-200/350-CKNTZ

¹ Former classification replaced by EN 14700

DESCRIPTION

- Tubular wire for self shielded metal arc hardfacing
- Cobalt hardened 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 CCo-O 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	4.50	2.30	Bal.

Structure: solid solution of the austenitic type

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

3 layers deposit on mild steel:

220HB

As welded:

Work hardened:

350HB

CONDITIONS OF USE

Current type			Protection			
DC (+)			self shielded			
OPERATING CONDITIONS						
Diameter [mm]		Amperage [A]		Voltage [V]		Stick-out [mm]
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	250 - 450	350	26 - 35	28	25 - 40	30
2.8	250 - 450	400	28 - 35	30	25 - 40	35
Recovery: 90 %						
WELDING POSITIONS						
Flat, half up, half down						
STANDARD DIAMETERS (mm)						
2.4, 2.8 mm						
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