

Classifications							
DIN 8555				ASME IIC SFA 5.21			
MF 20-GF-300-CTZ				ERC CoCr-E			
Characteristics							
Cobalt base wire designed to be used with the GTAW process (TIG). Alloy providing excellent resistance to metal-to-metal wear, thermal shocks, oxidation in corrosive environments at high temperature.							
Microstructure:		Cr and Mo carbides in an austenitic matrix					
Machinability:		Good					
Oxy-acetylene cutting:		Cannot be flame cut					
Deposit thickness:		Depends upon application and procedure used					
Shielding gas:		Argon 100%					
Field of use							
Extrusion dies, hot working tools, turbine injectors, valve seats, ingot tong bits.							
Typical analysis in %							
C	Mn	Si	Cr	Ni	Mo	Co	Fe
0,27	1,0	1,2	28,0	2,4	5,0	balance	3,5
Typical mechanical properties							
Hardness as welded: 32 HRC							
Recommended welding parameters							
Wire diameter [mm]	Amperage [A]	Voltage [V]		Stick-Out [mm]	Gas-Rate [L/min]		
1,6	150-250	20-31		20 max.	15-18		