

Classifications

DIN 8555

MF 20-GF-40-CTZ

Characteristics

Cobalt base wire designed to be used with the GTAW process (TIG). Alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature.

Microstructure: Cr and W carbides in an austenitic matrix

Machinability: Good with metallic carbide tipped tools

Oxy-acetylene cutting: Cannot be flame cut

Deposit thickness: Depends upon application and procedure used

Shielding gas: Argon 100%

Field of use

Valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches.

Typical analysis in %

C	Mn	Si	Cr	Co	W	Fe
0,95	0,8	0,8	31,5	balance	5,0	3,0

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18