

<b>International standards</b>	AWS A5.13	ECoCr-B
	DIN 8555	E 20-UM-50-CTZ

**Approvals** ---

**Characteristics** AC-weldable hardfacing electrode with a rutile-basic coating and an alloyed core. The deposit is a cobalt base alloy of austenitic-ledeburitic structure with embedded CrW carbides.  
The weld metal is highly resistant to corrosion, impact, abrasive wear as well as thermal shocks and heavy mechanical impact.  
.The deposit is only machinable by hard faced tools.

**Welding instructions** Working temperature should be kept between 400° and 600°C, depending on base material and type of construction. Slow cooling, if necessary oven cooling, is recommended for low alloyed and austenitic steels. Subsequent heat treatment ( stress relief at 700°C approx.) is not necessary, except on large structures.

**Operating temperature** From room temperature up to + 600° C

**Typical applications** Hardfacing of cutting edges of long knives and other tools used in the wood, plastic, paper, carpet and chemical industry.

<b>Mechanical properties of all-weld metal</b> ( typical values )	<b>At Rt. HRc</b>	<b>+ 300°C HRc</b>	<b>+ 600°C HRc</b>	<b>Melting- range °C</b>	<b>Density g/cm<sup>3</sup></b>
	ca. 48	ca. 37	ca. 32	1280-1320°C	8,7

<b>Weld metal analysis</b> (typical, wt. %)	<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>W</b>	<b>Fe</b>	<b>Co</b>	<b>Others</b>
	1,4	1	1	287	8,5	3	Base	< 3

**Current** = + / ~ 42 V

**Welding positions** PA, PB, PC

**Rebaking** 1 h, 350 + / - 10 °C ( if required )

**Flux-cored wire equivalent** CARBO F- S 12

<b>Dia./Length</b>	<b>Amperage (A)</b>	<b>Pcs./packet</b>	<b>Pcs./carton</b>	<b>kg/1000</b>	<b>kg/packet</b>	<b>kg/carton</b>
3,2 x 350	70 - 110	140	560	35,7	5,0	20,0
4,0 x 350	100 - 140	103	412	48,6	5,0	20,0
5,0 x 350	140 - 180	64	254	78,7	5,0	20,0

Recv. 000