

Classifications

EN 14700	AWS A 5.21
R Co3	ER CoCr-C

Characteristics and field of use

WEARtig Co 1 is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, erosion, corrosion, cavitation, pressure and high temperatures up to 900°C, such as working parts in the chemical industry, running and sealing surfaces of fittings, valve seats and cones for combustion engines, cutting and shredding tools, heavy-duty hot working tools without thermal shock, milling, mixing and drilling tools.

Excellent gliding characteristics, good polishability, slightly magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of pure weld deposit:	54 – 56 HRC
Hardness at 600°C:	approx. 42 HRC
Hardness at 600°C:	approx. 34 HRC

Rod analysis in %

C	Cr	W	Co
2.3	32	13	balance

Welding instruction

Clean welding area, preheating temperature 500-600°C, very slow cooling.

Welding procedure and availability

Ø x length	Current type	Shielding gas (EN ISO 14175)
3.2 x 1000 mm	DC (-)	I 1

Adjust acetylene excess (reducing flame) in oxyacetylene welding.

Approvals

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