

## Wear at elevated temperatures

### GENERAL DESCRIPTION

Cobalt base hardfacing electrode for abrasion and corrosion resisting surfacing.

Good resistance to high temperatures and to metal to metal friction.

High hardness at elevated temperatures (up to 1000 °C (1830 °F)).

Returns to its original hardness upon cooling.

Resistant to petroleum, plastic, rubber.

Also resistant to food, nitric acid (up to 70% at room temperature), acetic acid, sulphuric acid (up to 60 °C (140 °F) - 10% conc.).

### APPLICATIONS

Knives, valve seats, rollers, extrusion screws for the rubber and plastic industry, bearings, ...

All components subject to metal to metal friction.

Hardness: 52 - 60 HRC.

Hot hardness: 30 - 40 HRC @ 650 °C (1200 °F).

### CHEMICAL COMPOSITION (%) (Typical values, all weld metal)

C : 2.00 - 2.60	Cr : 29.00 – 32.00	Mo : < 1.00	Si : 1.50 – 1.90	W : 12.00 – 14.00
Fe : < 3.00	Ni : < 3.00	Co : Balance		

### MECHANICAL PROPERTIES (Typical values, all weld metal)

Yield Strength N/mm <sup>2</sup>	Tensile Strength N/mm <sup>2</sup>	Elongation 5d (%)	Impact Strength Charpy V notch (ISO-V)

### GENERAL INFORMATION

<b>Welding positions</b>	All, except vertical down.		
<b>Shielding gas</b>	NA		
<b>Packing</b>	5 Kg in a plastic box		
<b>Polarity</b>	AC or DC, Reverse polarity (electrode positive)		
<b>Diameter (mm)</b>	3.2	4.0	5.0
<b>Length (mm)</b>	350	350	350
<b>Approx. current (A)</b>	80 - 95	100 - 130	130 - 170

<b>Tips &amp; Tricks</b>	Remove all rust and dirt. Sharp edges must be rounded for optimum adhesion. The arc should be short to avoid too much dilution with the base metal. On crack sensitive steels, apply a buttering layer with Modi Lastek 9066.
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*The information in this document is based on intensive tests and is accurate to the best of our knowledge. Do note that these values are only typical values for tests in accordance to prescribed standards. The suitability of the product should always be confirmed by qualification tests before use in any application. The information can be changed without previous notice.*