



Selectarc Co25

*Cobalt base Hardfacing
Electrode "Grade25" type*

Description & Applications

Surfacing electrode with a rutile-basic coating. Cobalt base deposit of « grade 25 » type (Co-Cr-W-Ni). Deposit characterised by a good resistance to metal-metal wear and oxidation resistant up to 1000°C. Good behaviour to important thermal and mechanical shocks. Excellent resistance to cracks, highly resistant to cavitation and erosion, deposit non-magnetic.

General applications : Surfacing of motor valves, gas turbine blades, extrusion nozzles, forging dies, forging tools.

All Weld Metal Mechanical Properties

Hardness (as welded) +20°C
~ 230 HB

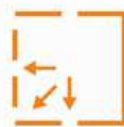
Hardness at +600°C
~300 HB

Welding Current & Instructions

Electrode	ØxL (mm)	3,2x350	4,0x350
Current	(A)	100	140

Redrying 1h at 250°C, if necessary. Preheat massive pieces 250-400°C. Keep this temperature during welding, cool down slowly after welding to reduce the risk of cracking while cooling.

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= + ~ 70V

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