



FCW CO1

*Cobalt grade 1
Tubular flux cored wire*

Classification

AWS A5.21 : ERCCoCr-C

EN 14700 : T Co3

Description & Applications

Cobalt base tubular wire for gas shielded (100% Ar) hardfacing type Cobalt Grade 1. Exceptional resistance to metal-metal wear or abrasion in corrosive media at high temperature up to +800°C combined with low or moderate shocks.

Main applications: Steam valves, wire guide, rubber and plastic mixers, extrusion crews, conveyors...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S	Co
Min	0.15			25				11			
Max	0.40	2.0	2.0	30	3.0	1.0	5.0	14	0.03	0.03	Rem.
Type	2.3	1.0	1.0	29.0	0.01	0.01	4.0	12.0	0.01	0.01	Rem.

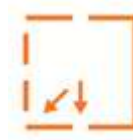
Σ Others elements : <1.0

All Weld Metal Mechanical Properties

Hardness (3 rd layer)				
As welded	+200°C	+400°C	+600°C	+800°C
53 HRC	540 HB	480 HB	400 HB	220 HB

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Intensity (A)	Voltage (V)	Stick out (mm)	
FCAW = + / pulsed	1.2 1.6	100 - 250 140 - 350	16 - 29 16 - 30	15 - 30	ISO 14175 : I1 (100% Ar) 10-20 l/min



FT En-CC01-180920

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