



FCW CO12

*Cobalt grade 12
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 12. Exceptional resistance to metal-metal wear or abrasion in corrosive media at high temperature up to +800°C combined with erosion and thermal shocks.

Main applications: Saw teeth, cams, shafts, seats and valves, rubber and plastic mixers, screw conveyors...

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S	Co
Min	1.2		0.1	25				7			
Max	2.0	2.0	2.0	32	3.0	1.0	5.0	10	0.03	0.03	Rem.
Type	1.6	1.0	1.5	29.0	0.01	0.01	3.0	8.0	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
46 HRC	420 HB	380 HB	360 HB	230 HB

Welding Current & Instructions

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

FT En-CC03-180920



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