



FCW CO21

Classification

AWS A5.21 : ERCCoCr-E

EN 14700 : T Co1

Description & Applications

Cobalt base tubular metal-cored wire for gas shielded (Ar 100%) hardfacing type Cobalt Grade 21. Exceptional resistance to wear combined or not to shock, corrosion resistant to high temperature pressure in sulphurous atmosphere up to 900°C.

Main applications: Scope and valve seats, hot forging dies, gas turbine, large hardfacing areas.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Fe	W	Nb	P	S	Co
Min	0.15		0.1	25	1.5	4.5						
Max	0.40	1.5	2.0	30	4.0	7.0	5.0	0.50	1	0.03	0.03	Rem.
Type	0.25	1.1	1.0	28.5	3.0	5.5	3.5	0.01	0.01	0.01	0.01	Rem.

Σ Others elements : <1.0

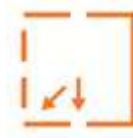
All Weld Metal Mechanical Properties

Hardness (3rd layer)

~ 33 HRC as welded

Welding Current & Instructions

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



FT En-CC04-210415

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