



MIG 22/21CO

Classification

ISO 14343-A : G Z 22 21 3 CoWNbN

AMS : 5794

Description & Applications

Solid wire for GMAW of similar chemical composition alloys. Good resistance to heat and corrosion.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	W	Nb	P	S	Co	N	Ta
Min			1.00	20.00	19.00	2.50	2.00	0.75			18.50	0.10	
Max	0.10	1.00	2.00	22.50	21.00	3.50	3.00	1.25	0.04	0.03	21.00	0.20	0.05
Type	0.08	0.40	1.4	22.0	20.5	3.2	2.8	1.0	0.01	0.005	20.0	0.15	0.015

All Weld Metal Mechanical Properties

	R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
Min	-	-	-	-
Max	-	-	-	-
Type	320	410	40	-

* After PWHT at 1200°C/1h/Air

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	Voltage (V)	
GMAW = +	0.8	70 - 180	18 - 26	ISO 14175: M12 (Ar+0.5-5%CO ₂) M13 (Ar+0.5-3%O ₂) 15-20 l/min
	1.0	80 - 220	18 - 28	
	1.2	150 - 320	22 - 32	
	1.6	220 - 380	24 - 34	

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