



MIG CO25

Classification

AMS : 5796 EN 14700 : S Z Co1
DIN 8555 : MSG 20-GZ-250-CKTZ

Description & Applications

Cobalt base solid wire for GMAW harfacing of Stellite™ Grade 25*. 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, work hardenable, highly resistant to cavitation and erosion. Deposit non-magnetic.

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

* Trademark Kennametal

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Fe	W	Nb	P	S	O/T	Co
Min	0.05		1.00	19.00	9.00			14.00					
Max	0.15	1.00	2.00	21.00	10.00		3.00	16.00		0.04	0.03	0.50	Rem.
Type	0.10	0.70	1.2	19.8	9.8	0.03	2.0	15.0	0.01	0.02	0.015	<0.50	Rem.

All Weld Metal Mechanical Properties

Hardness (as welded)
~230 HB

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	(V)	
MIG = +	1.2 1.6	140-180 160-200	22-27 24-28	ISO 14175: I1(Ar) / M11 (Ar/CO ₂) 18 L/min

Preheat large components or special steels to 200-400°C. Keep this temperature during welding and cool down slowly, preferable in an oven, to reduce the risk of cracking while cooling.

FT En-MB05-200309

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