



MIG FICO25

Classification

AMS : 5796
EN 3887 : CoCr20W15Ni

AFNOR : KC20WNx

Description & Applications

Cobalt base solid wire for GMAW harfacing of Cobalt Grade 25* and alloy with similar chemical composition. 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.

Base material: Alloy 25, L-605, UNS R30605, AMS5537, 2.4964, CoCr20W15Ni and similar Cobalt alloys.

Main applications: Aeronautic industry.

* Trademark Kennametal

Typical Chemical Composition (%)

| | C | Si | Mn | Cr | Ni | Fe | W | P | S | Co |
|------|------|------|------|-------|-------|------|-------|-------|-------|------|
| Min | 0.05 | | 1.00 | 19.00 | 9.00 | | 14.00 | | | |
| Max | 0.15 | 1.00 | 2.00 | 21.00 | 11.00 | 3.00 | 16.00 | 0.040 | 0.030 | Rem. |
| Type | 0.10 | 0.80 | 1.5 | 20.0 | 10.0 | 2.5 | 15.0 | 0.010 | 0.010 | 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.

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