



## TIG FICO31

### Classification

AMS : 5789  
EN 4327 : CoCr26Ni11W8

AFNOR : KC 25 NW

### Description & Applications

Cobalt base solid rod for TIG harfacing of Cobalt Grade 31 and alloy with similar chemical composition. Creep resistant and oxidation resistant up to 1150°C. Good behaviour to important thermal and mechanical shocks.

**Main applications:** Aeronautical industry.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Fe	W	P	S	Co
Min	0.45			24.50	9.50		7.00			
Max	0.55	1.00	1.00	26.50	11.50	2.00	8.00	0.040	0.040	Rem.
Type	0.50	0.80	0.80	25.5	10.5	1.0	7.5	0.010	0.005	Rem.

### All Weld Metal Mechanical Properties

Hardness (as welded)  
~ 30 HRC

### Welding Current & Instructions

Welding mode	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 L/min

FT En-TC02-170712

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