



TIG FICO918

Classification

AMS : 5814
GE B50A824

AFNOR : KC20NTa

Description & Applications

Cobalt base solid rod for TIG hardfacing of jet engine or turbine parts. Excellent resistance to corrosion and high temperature.

Main applications: Aeronautical industry.

Typical Chemical Composition (%)

| | C | Si | Mn | Cr | Ni | Fe |
|------|---------|---------|---------|--------|--------|------|
| Min | 0.04 | | | 19.0 | 19.0 | |
| Max | 0.10 | 0.20 | 0.10 | 21.0 | 21.0 | 0.50 |
| Type | 0.07 | 0.10 | 0.01 | 20.0 | 20.0 | 0.05 |
| | Cu | Zr | Al | P | S | Ta |
| Min | | | | | | 7.0 |
| Max | 0.15 | 0.02 | 0.10 | 0.01 | 0.008 | 8.0 |
| Type | 0.05 | 0.01 | 0.07 | <0.01 | <0.005 | 7.5 |
| | Pb | Bi | Ag | Sn | Co | |
| Min | | | | | | |
| Max | 0.0025 | 0.0025 | 0.0025 | 0.0050 | Base | |
| Type | <0.0025 | <0.0025 | <0.0025 | <0.005 | Base | |

All Weld Metal Mechanical Properties

Hardness (as welded)

-

Welding Current & Instructions

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

FT En-TC07-170717

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