

Classifications

DIN 8555	EN 14700	AWS A 5.21
WSG 20-GO-50-CSTZ	R Co3	~ER CoCr-B

Characteristics and field of use

WEARtig Co 12 is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, erosion, corrosion, cavitation, pressure and high temperatures up to 900°C, such as sealing and gliding surfaces of fittings and pumps, valve seats and cones for combustion engines, tools for wood, paper and plastic industries, gliding surfaces metal to metal, milling, mixing and drilling tools, heavy-duty hot work tools without thermal shock.

Excellent gliding characteristics, good polishability, non-magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of pure weld deposit: 48 – 50 HRC
 Hardness at 500°C: approx. 40 HRC

Rod analysis in %

C	Cr	W	Co
1.8	29.0	8.5	balance

Welding instruction

Clean welding area, preheating temperature 500-600°C, very slow cooling.

Welding procedure and availability

Ø x length	Current type	Shielding gas (EN ISO 14175)
3.2 x 1000 mm	DC (-)	I 1
4.0 x 1000 mm	DC (-)	I 1
5.0 x 1000 mm	DC (-)	I 1

Adjust acetylene excess (reducing flame) in oxyacetylene welding.

Approvals

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