

Classifications

DIN 8555	EN 14700	AWS A 5.21
WSG 20-G0-300-CKTZ	R Z Co1	ER CoCr-E

Characteristics and field of use

WEARtig Co 21 is a CoCrMo-alloyed rod for TIG and gas welding and especially suitable for hardfacing of parts subject to a combination of pressure, impact, abrasion, corrosion and high temperatures up to 900° C, such as running and sealing faces of gas-, water-, steam- and acid fittings and pumps; valve seats and cones for combustion engines; working parts on turbines and power plants; hot-working tools with frequent changes of high thermal load.

Properties of the weld metal

Excellent gliding characteristics, very good polishability, high toughness, non-magnetic.

Hardness of the pure weld deposit: 30 - 32 HRC
 Work-hardened: approx. 45 HRC
 Hardness at 600°C: approx. 240 HB

Rod analysis in %

C	Cr	Mo	Ni	Co
0.25	28.0	5.0	2.8	balance

Welding instructions

Clean welding area, preheat to 150 - 400° C, depending on size of the workpiece and base material. Slow cooling.

Welding procedure and availability

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

Adjust acetylene excess (reducing flame) in oxyacetylene welding.