

Classifications

AWS A5.13 / SFA-5.13	DIN 8555	EN 14700
E CoCr-B	E 20-UM-50 CSTZ	E Co3

Characteristics and typical fields of application

WEARstick Co 12 is used for highly wear-resistant hardfacings on parts subject to a combination of abrasion, erosion, cavitation, corrosion, pressure and high temperatures up to 900 °C, such as running, sealing and gliding faces on fittings and pumps; tools for wood, paper, plastic; shredding tools; highly stressed hot-working tools not subject to thermal shock.

Machining by grinding or with tungsten carbide cutting tools.

WEARstick Co 12 has excellent welding properties and a homogeneous, finely rippled seam. Very easy slag removal.

Hardness of the pure weld deposit

Hardness at RT: 48 – 50 HRC

Hardness at 500 °C: approx. 40 HRC

Hardness at 700 °C: approx. 33 HRC

Typical analysis

	C	Cr	W	Co
wt.-%	1.6	29	8.5	Bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
			3.2 × 350	70 – 110
			4.0 × 350	90 – 130

Welding instructions

Clean welding area, preheating temperature 500 - 600 °C, very slow cooling. Hold stick electrode vertically and with a short arc and lowest possible amperage. Re-dry stick electrodes that have become damp for 2h / 300 °C.

Approvals

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