

Classifications

AWS A5.13 / SFA-5.13	EN 14700	DIN 8555
ECoCr-E	E Co1	E 20-UM-350-CTZ

Characteristics and typical fields of application

WEARstick Co 21 is used for crack-resistant hardfacings on parts subject to a combination of impact, pressure, abrasion, corrosion and high temperatures up to 900 °C, such as running and sealing faces on gas, water, steam and acid fittings and pumps, valve seats and cones for combustion engines, working parts in gas and power plants, hot-working tools with changing thermal load.

Excellent gliding characteristics, good polishability and toughness, highly work-hardening, nonmagnetic, machinable with cutting tools.

WEARstick Co 21 has excellent welding properties and a homogenous, finely-rippled seam. Very easy slag removal.

Hardness of the pure weld metal: 31 – 37 HRC

Work-hardened: approx. 45 HRC

Hardness at 600 °C: approx. 240 HB

Typical analysis

	C	Cr	Ni	Mo	Co
wt.-%	0.3	26.0	3.5	5.0	Bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2 h / 300° C	3.2 × 350	80 – 120
			4.0 × 350	110 – 140

Welding instructions

Clean welding area, preheating temperature 150 – 400 °C, depending on the size of the workpiece and the base material. Slow cooling. Hold stick electrode vertically and with a short arc and lowest possible amperage.

Redry stick electrodes that have become damp for 2h / 300 °C

Approvals

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