

## Classifications

EN 14700	DIN 8555
E Z Co1	E20-UM-250-CKTZ

## Characteristics and typical fields of application

WEARstick Co 25 is suited to production and repair of hot-working tools subject to extreme temperatures, thermal shock, compression, impact and abrasion. Main application fields are hot dies, hot pressing blades, hot trimming tools and roll mandrils. Special applications are between-layer build-ups on workpieces in nuclear reactor engineering.

WEARstick Co 25 shows excellent welding properties, good weld pool control, regular bead appearance and easy slag removal. The weld deposit is highly corrosion and scaling-resistant, has a high work-hardenableity and is heat-resistant up to 900 °C. Machinable with cutting tools.

Hardness of the pure weld deposit:

As welded: approx. 230 HB

Work-hardened: approx. 450 HB

## Typical analysis

	C	Si	Mn	Cr	Ni	W	Co	Fe
wt.-%	0.1	0.5	1.2	21.0	11.0	14.0	bal.	2.0

## Operating data

	<b>Polarity</b>	DC + / AC	<b>Dimension mm</b>	<b>Current A</b>
			3.2 × 350	80 – 120

## Welding instructions

Clean welding area, preheat tools to 350 - 400 °C and maintain this temperature during the whole welding process. Slow cooling in a furnace. Hold stick electrode vertically and with a short arc. Select lowest possible amperage in order to reduce dilution with the base metal. Re-dry damp stick electrodes for 2 h/300 °C.

## Approvals

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