

| Classifications | | | | | | |
|---|---|-------------|-------------------|------------------|-----|-----|
| DIN 8555 | | | ASME IIC SFA 5.21 | | | |
| MF 20-GF-40-CTZ | | | ERC CoCr-A | | | |
| Characteristics | | | | | | |
| Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode. | | | | | | |
| Microstructure: | Cr and W carbides in an austenitic matrix | | | | | |
| Machinability: | Good with metallic carbide tipped tools | | | | | |
| Oxy-acetylene cutting: | Cannot be flame cut | | | | | |
| Deposit thickness: | Depends upon application and procedure used | | | | | |
| Shielding gas: | Argon 98% + Oxygen 2% or Argon 100% | | | | | |
| Welding flux (for dia. 2,4): | Record SA | | | | | |
| Field of use | | | | | | |
| Valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches. | | | | | | |
| Typical analysis in % | | | | | | |
| C | Mn | Si | Cr | Co | W | Fe |
| 0,95 | 0,8 | 1,4 | 30,0 | balance | 4,2 | 3,0 |
| Typical mechanical properties | | | | | | |
| Hardness as welded: 40 HRC | | | | | | |
| Recommended welding parameters | | | | | | |
| Wire diameter [mm] | Amperage [A] | Voltage [V] | Stick-Out [mm] | Gas-Rate [L/min] | | |
| 1,2 | 110-180 | 20-31 | 20 max. | 12-15 | | |
| 1,6 | 150-250 | 20-31 | 20 max. | 15-18 | | |
| 2,4 | 300-400 | 20-31 | 20 max. | 18-20 | | |