CARBO SK 21

Standards

DIN 8555	E 20-UM-300-CKTZ

Approvals ---

Characteristics

CARBO SK 21 is a rutile coated electrode which is AC weldable.
The deposit is a cobalt base alloy of high tenacity as well as extreme corrosion- and heat resistance.
The weld metal is highly resistant to impact and is work-hardening up to 45 HRC.
Working temperature should be kept between 400° and 600°C, depending on base material and type of construction. Slow cooling, if necessary oven cooling, is recommended for low alloyed and austenitic steels.
Subsequent heat treatment (stress relief at 700°C approx.) is not necessary, except on large structures.

Operating temperature From room temperature up to + 300° C

Typical applications

Due to its above-mentioned characteristics CARBO SK 21 is particularly recommended for use on all work pieces which are subject to corrosion, impact wear as well as high temperatures or thermal shocks.

Hardness of all-weld metal
(typical values **)**

At Rt. HRC	+ 300°C HB	work hardened HRC	Melting-point	Density g/cm³
ca. 30	ca. 280	ca. 280	1250°C	8,3

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Mo	Ni	Co	Fe
0,3	0,9	1	28	5,5	3	Base	3

Current = + / ~ 42 V

Welding positions PA, PB, PC

Rebaking 1 h, 350 + / - 10 °C (if required)

Flux-cored wire equivalent

CARBO F- S 21

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	40 - 75	235	939	21,3	5,0	20,0
3,2 x 350	70 - 110	140	560	35,7	5,0	20,0
4,0 x 350	100 - 140	103	412	48,6	5,0	20,0
5,0 x 350	140 - 180	64	254	78,7	5,0	20,0