

COROLIT[®] 21

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Co1 MF 20-350-CKTZ

GENERAL CHARACTERISTICS:

Cobalt base alloy with an austenitic structure bearing chrome and molybdenum carbides. This cobalt base-alloy is the toughest, with highest corrosion and thermal resistance of all common cobalt-base alloys. The weld deposit is work hardening, machinable and is used on components that are exposed to high temperatures, corrosion and impact stress, such as valve seats as well as components in the chemical industry. Due to possible cracks preheating to approx. 250°C is recommended.

Recommended gas: Argon with 1% oxygene

APPLICATION:

Abrasion, erosion, corrosion, cavitation at high temperatures, pumps, extrusion screws, bearing surfaces, chemical industry, hot shear blades, valves.

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Si	Mn	Cr	Ni	Mo	Co	Fe
0,25	1,0	1,0	27,0	2,5	5,0	bal.	< 3,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 300 - 330 HB

Work hardening: up to 45 HRc

PARAMETER:

Diameter	Voltage	Amps
1,2	20 - 24	150 - 200
1,6	22 - 26	180 - 240
2,0	25 - 27	220 - 260
2,4	25 - 27	260 - 300
2,8	26 - 28	280 - 340

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg

Coil "BS 450" = 25 kg

Drums = 300 kg

G = gas shielded, SA = Submerged Arc