

COROLIT[®] 6 HC

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Co2 MF 20-45-CTZ

GENERAL CHARACTERISTICS:

Cobalt base alloy with an austenitic structure bearing chrome and tungsten carbides. This alloy is resistant to high corrosion and abrasion, high impact stress and extreme temperature shocks. The deposit is machinable by hard metal tools. Best used on steam and chemical valves and on equipment handling hot steel, such as tong bits, shear blades, etc.. The hardness decreases at 300°C by approx. 16% and at 600°C by approx. 30%.

A buffer layer with CORODUR 200 K is recommended. Due to possible cracks preheating to approx. 350°C is recommended.

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 | Co | W | Fe |
|-----|-----|-----|------|------|-----|-------|
| 1,3 | 1,0 | 0,8 | 29,0 | bal. | 4,5 | < 3,0 |

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 43 - 46 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