COROLOY® 520 W

CLASSIFICATION:

DIN EN 14700	DIN 8555
T Ni2	MF 23-40-CKPTZ

GENERAL CHARACTERISTICS:

COROLOY 520 W deposits a Cr- Co- Mo- Ti- Al- W- alloy in a nickel base. The weld metal is a precipitated, easily hardened alloy with an exceptional combination of high temperature mechanical properties, formability and corrosion resistance. The alloy can be used for hot forging dies, hot working steels, hot shear blades, etc.
To obtain a crack-free weld, the base material should be preheated to 350°C and held. After the welding is completed, the cooling rate should be low.

APPLICATION:

Hot forging hammers, hot forgimg dies, pilger mandrels, highly heat resistant impact loaded claddings, repair von NiMoNi alloys

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Cr	Ni	Mo	Co	W	Ti	Al
0,05	20,0	bal.	6,0	10,0	4,0	3,0	2,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness: 32 - 35 HRc
Thermoset hardening: 35 - 45 HRc

PARAMETER:

Diameter	Voltage	Amps
1,6	23 - 26	180 - 260
2,0	24 - 27	240 - 280
2,4	25 - 27	280 - 340
2,8	25 - 28	320 - 400

FORMS OF DELIVERY:

Coil "BS 300" = 15 kg	Coil "BS 450" = 25 kg	Drums = 300 kg

G = gas shielded

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