

COROLOY Co

CLASSIFICATION:

DIN EN 14700 DIN 8555
T Ni2 MF 23-250-CKNPTZ

GENERAL CHARACTERISTICS:

COROLOY Co is a high alloyed Cr- Mo- Co- W- flux cored Nickel based wire. This alloy is suitable for steel that encounters aggressive corrosive media as well as those steels that operate at high temperatures. This hardfacing alloy is extraordinarily resistant on impact, pressure loads and high temperature environments, which results in hardening of the deposit up to a hardness of about 420 HB with little deformation. When build-up layers are required, CORODUR 200 K is recommended as a buffer layer. It is also recommended that the base material should be preheated to about 300°C – 400°C before hardfacing. For multi layer welding low interpass temperature and low energy input is recommended.

APPLICATION:

Hot forging dies, forging plant parts, hot shear blades, hammer and hammer-saddles, repair of injection moulding castings, piercing mandrels, buffering alloy for forging hammer-saddles and hammers

TYPICAL ALL WELD METAL ANALYSIS (%):

C	Cr	Ni	Mo	Co	V	W	Fe
0,08	16,0	bal.	16,0	2,5	0,35	4,5	< 5,0

TYPICAL ALL WELD METAL MECHANICAL PROPERTIES:

Hardness weld deposit	Work hardening	Precipitation hardening 900°C/Air	Elongation
260 – 280 HB	approx. 420 HB	approx. 430 HB	approx. 20%

PARAMETER:

Abmessung	Voltage	Amps
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

OA = gasless, G = gas shielded, SA = Submerged Arc