



ERCoCr-C Filler Wire

Shanti Metal Supply Corporation ERCoCr-C Filler Wire

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CODE & SPECIFICATION DATA:

AWS A5.21 ASME SFA A5.21

AWS Chemical Composition Requirements	
Element	Composition (%)
Carbon (C)	2.0 - 3.0
Molybdenum (Mo)	1.0 max
Manganese (Mn)	1.0 max
Iron (Fe)	3.0 max
Silicon (Si)	2.0 max
Tungsten (W)	11.0 - 14.0
Chromium (Cr)	26 - 33
Cobalt (Co)	Remainder
Nickel (Ni)	3.0 max
Other Elements	0.50 max

Deposited Chemical Composition % (Typical)	
Element	Composition (%)
Carbon (C)	2.4
Molybdenum (Mo)	0.1
Manganese (Mn)	0.06
Iron (Fe)	2.3
Silicon (Si)	1.2
Tungsten (W)	12.2
Chromium (Cr)	31
Cobalt (Co)	Balance
Nickel (Ni)	2.2

Application

Shanti Metal Supply Corporation offers Type #1 bare wire/rod, the hardest cobalt alloy, ideal for high-temperature wear. It bonds well with stainless steel and weldable grades, machinable with carbide tools.

Recommended Operation of Welding Rods [GTAW (tig)]			
Electrode Size (in)	Amperage Range	Voltage Range	Shielding Gas
01-Aug	90 – 120	20 – 40	Argon
May-32	120 – 140	20 – 40	Argon
Mar-16	140 – 180	20 – 40	Argon

Deposited All Weld Metal Properties % (AW)	
Property	Value
Hardness (2 layers)	HRC 53 – 54

