

<b>Classifications</b>						
DIN 8555			ASME IIC SFA 5.21			
MF 20-GF-40-CTZ			ERC CoCr-A			
<b>Characteristics</b>						
Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode.						
Microstructure:	Cr and W carbides in an austenitic matrix					
Machinability:	Good with metallic carbide tipped tools					
Oxy-acetylene cutting:	Cannot be flame cut					
Deposit thickness:	Depends upon application and procedure used					
Shielding gas:	Argon 98% + Oxygen 2% or Argon 100%					
Welding flux (for dia. 2,4):	Record SA					
<b>Field of use</b>						
Valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches.						
<b>Typical analysis in %</b>						
C	Mn	Si	Cr	Co	W	Fe
0,95	0,8	1,4	30,0	balance	4,2	3,0
<b>Typical mechanical properties</b>						
Hardness as welded: 40 HRC						
<b>Recommended welding parameters</b>						
Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]		
1,2	110-180	20-31	20 max.	12-15		
1,6	150-250	20-31	20 max.	15-18		
2,4	300-400	20-31	20 max.	18-20		