



Die

Cobalt base alloy with superior wear properties for critical surfacing and repair applications at high temperatures

Typical Applications:

Hydraulic turbine parts, hot cutting tools, chemical and high pressure steam valves, hot forming rolls and dies, augers, exhaust valves.

Outstanding Features:

- Cobalt based alloy having high resistance to corrosion, impact, friction, abrasion and erosion.
- Superior resistance to thermal shock & oxidation.
- Outstanding weldability with excellent deposit crack-resistivity.
- Easily machinable & work hardenable.

Recommendation:

For all steels, including the heat-treatable types. Also for overlay applications on cobalt alloys and special purpose steels.

Procedure:

Clean weld area. Remove all fatigued and cracked metal and previous overlays. Preheat generally not required but beneficial when welding heavy sections or crack-sensitive base metals. Maintain short gap and deposit stringer beads. Back-whip craters. Remove slag between passes. For out-of-position, hold shorter arc and weave moderately.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	90 - 100	70 - 90
4.00	120 - 140	90 - 120
5.00	150 - 170	120 - 150

Hardness: 25 - 35 HRc (3 layer)