Feed Screw

Cobalt alloy based electrode with excellent resistance to heat, impact and abrasion

Typical Applications:

Hot pressing dies, shear blades, hot cutting blades, hot hardness dies.

Outstanding Features:

- Exceptional resistance to heat with high hot hardness.
- Good all-round resistance to impact and abrasion.
- Dense deposit with excellent bead formation.

Recommendation:

Cobalt alloy electrodes for producing excellent wear resistant overlays on carbon and alloy steels. Excellent results obtained even when high temperature service conditions prevail. Provides ease of deposition and freedom from porosity, cracking and other faults common in products of this type. Recommended for handling equipment for hot steel, dies etc.

Procedure:

Clean weld area. Remove fatigues or damaged metal with EWAC GaugeTec. Remove all sharp corners and projections. Grind all surfaces to remove oxides and other contaminants. Preheat if necessary for low carbon, air hardenable steels and cast iron. For cast iron and air hardenable steels deposit a buttering layer of EWAC CI 422 and EWAC ST 202 HD respectively. Then deposit the cobalt alloy. For low carbon steel the alloy can be deposited directly.

Recommended Amperages:

Size (mm)	Amperage
3.15	70 - 100
4.00	100 - 150
5.00	130 - 190

Hardness: 40 - 50 HRc (3 layer)