

Technical data sheet 011121MBA	Cored welding wire HARDFACE DCO-O	 Welding Alloys
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CLASSIFICATION

EN 14700: T ZFe3

DESCRIPTION

- Metal cored wire for metal arc hardfacing without gas shielding
- Cr-Co-Mo alloying gives properties comparable to those of cobalt based products
- Suitable for withstanding corrosion and metal-metal wear at temperatures up to 550°C
- Resists cracking and thermal shock
- An economical alternative to stellite

APPLICATIONS

HARDFACE DCO-O is used for depositing wear-resistant surfaces on hot-working tools

Examples

Surfacing of hot working stamping punches and dies. Hardfacing continuous casting rollers, Surfacing of diesel and steam valves.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Co	Mo	Ni
0.15	0.4	0.7	14.5	12.5	2.5	0.5

Structure: highly alloyed martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded (3-layer deposit): 45 - 52 HRc

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 – 350	270	24 – 35	28	25 – 50	25
2.0	200 – 400	300	26 – 35	28	25 – 50	35
2.4	250 – 450	350	26 – 35	28	25 – 50	40
2.8	250 – 450	400	28 – 35	30	25 – 50	40

Recovery: 90%

WELDING POSITIONS

Flat, half up, half down

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.