

Technical data sheet <small>011121MBA</small>	Cored welding wire STELLOY CCo-G	 Welding Alloys
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CLASSIFICATION

EN 14700 : T Ni2

DESCRIPTION

- Cobalt hardened nickel-based super-alloy flux-cored wire of the NiCrMoW type
- Particularly resistant to corrosion under oxidising and reducing atmospheres
- The weld deposit withstands impact, compression, friction, oxidation, corrosion and heat up to 1100°C
- Excellent thermal shock resistance
- Can be machined without previous heat treatment

APPLICATIONS

STELLOY CCo-G is suitable for surfacing parts undergoing oxidation, corrosion and mechanical stresses at high temperature

Examples

Extrusion mandrels and dies, hot shearing blades, forging dies

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe	W	Co	Ni
0.05	1	0.6	15.5	16	3	4.5	2.3	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel:

As welded: 220 HB

Work hardened: 350 HB

CONDITIONS OF USE

Current type	Shielding gas	Gas flow rate
DC+ or pulsed	EN ISO 14175: I1 (Argon)	10 - 20 l/min.

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	140 - 350	250	16 - 30	28	15 - 25	20
2.4	250 - 350	300	26 - 30	28	15 - 25	20

Recovery: 95 %

WELDING POSITIONS

Flat, half up, half down, all positions

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.