


Technical data sheet <small>011121MBA</small>	Coated SMAW Electrode WA STELLOY CCo-E	 Welding Alloys
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CLASSIFICATION

EN 14700: E Ni2

DESCRIPTION

- Synthetic basic coated hardfacing electrode
- Cobalt hardened nickel-based super-alloy 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

APPLICATION

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

Examples

Extrusion mandrels and dies, hot shearing blades, forging dies, hot-working tools, etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Fe	W	Co	Ni
0.05	1	0.5	16	16	3	4.0	3.5	Bal.

Structure: austenite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness – 3-layer deposit on mild steel:

As welded: 220 HB
 Work hardened: 350 - 400 HB
 Machinability: good

OPERATING CONDITIONS

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Current [A]	80 - 100	90 - 160	130 - 180

Recovery: 170%

WELDING POSITIONS

EN ISO 6947: PA, PB
 ASME IX: 1G, 2F

PACKAGING

Electrode Ø x L [mm]	3.2 x 350	4.0 x 450	5.0 x 450
Weight/box [kg]	5	6.5	6.5

Other packaging and other sizes: please consult us