


Technical data sheet <small>EN190423GB</small>	Cored welding wire STELLOY 21-LD	 Welding Alloys
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CLASSIFICATION

EN 14700: T Co1
ASME IIC SFA 5.21 / AWS A 5.21: ERCCoCr-E

DESCRIPTION

- Cobalt base tubular wire developed for laser welding
- Produces weld beads with minimal slag island formation
- Can also be used for TIG or plasma welding
- Excellent metal-to-metal wear resistance combined with good corrosion resistance

APPLICATIONS

- STELLOY 21-LD is used for hardsurfacing parts subjected to a combination of impact, abrasion, compression, corrosion and high temperatures
- The toughness of the deposit allows excellent resistance to thermal cycles and shocks
- Less crack sensitive than other cobalt base alloys, STELLOY 21-LD is used for building up large-scale sections

Examples

- For use on parts such as integral seats and guides of large water and high-pressure valve bodies, drop forging dies, pump shafts and sleeves, hot punches

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Fe	Co
0.25	1	1	28.5	3	5.5	4	Bal.

Structure: high carbides in a CoCrMo austenitic matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness: as welded: 33 HRC
Work-hardened: 47 HRC

PACKAGING

Diameter	1.2 mm – 1.6 mm
Standard packaging	EN ISO 544: BS300
Weight	15 kg

Other packaging and other diameters: please consult us