

Technical data sheet <small>EN020524GB</small>	Cored welding wire HARDFACE DCO-G	
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CLASSIFICATION

EN 14700: T Z Fe3

DESCRIPTION

- Metal cored wire for gas shielded arc welding
- Special martensitic alloyed steel offering similar performance to cobalt based alloys
- The Fe-Cr-Co-Mo welding deposit is especially suited to resist metal-to-metal wear, oxidation, and corrosion at temperatures up to 600 °C
- Economic alternative to cobalt based alloys

APPLICATIONS

HARDFACE DCO-G is used for surfacing of hot working stamping punches, dies, casting rollers, ect.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Co	Fe
0.15	0.5	0.8	13.5	0.6	3.0	13.0	Bal.

Structure: highly alloyed martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

As welded, 3-layer on mild steel: 45 - 52 HRC

Tensile:

Ultimate Tensile Strength: 1450 MPa

CONDITIONS OF USE

Current type	Gas-shielding
DC (+)	M21: Ar + 15 - 25 % CO ₂
	M20: Ar + 5 - 15% CO ₂
	M12: Ar + 2 - 5 % CO ₂
	C1: CO ₂

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.2	100 - 300	220	20 - 30	26	15 - 25	20
1.6	150 - 350	270	25 - 35	27	20 - 30	25
2.0	200 - 400	300	25 - 35	28	20 - 30	25
2.4	250 - 450	350	25 - 35	28	20 - 30	25

Recovery: 95 %

WELDING POSITIONS

EN ISO 6947: PA, PB

ASME IX: 1F, 1G, 2F

HARDFACE DCO-G (Ø 1.2 & 1.6 mm) is primarily used in the flat and horizontal-vertical positions. However, out of position welding is also possible using short circuit or pulsed arc modes of transfer

PACKAGING

Diameter	1.2 - 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.