

Technical data sheet <small>EN030524GB</small>	Cored welding wire HARDFACE DCO-S	 Welding Alloys
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CLASSIFICATION

EN 14700: T Z Fe3

DESCRIPTION

- Cored wire for submerged 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
- Crack free deposit, high hardness achieved from the first layer
- Economic alternative to cobalt based alloys

APPLICATIONS

HARDFACE DCO-S 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

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	250 - 450	350	25 - 35	30	25 - 35	30
2.8	300 - 500	400	25 - 35	30	25 - 35	30
3.2	350 - 550	450	25 - 35	30	25 - 35	30

Recovery : 95 %

Current type/polarity: DC+

WELDING POSITIONS

Flat

PACKAGING

Diameter	2.4 - 3.2 mm	
Standard packaging (EN ISO 544)	B 450 coil	Drum
Weight	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.