

<b>Classifications</b>			
EN 14700		AWS A 5.21	
R Co3		ER CoCr-C	
<b>Characteristics and field of use</b>			
<p>WEARtig Co 1 is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, erosion, corrosion, cavitation, pressure and high temperatures up to 900°C, such as working parts in the chemical industry, running and sealing surfaces of fittings, valve seats and cones for combustion engines, cutting and shredding tools, heavy-duty hot working tools without thermal shock, milling, mixing and drilling tools.</p> <p>Excellent gliding characteristics, good polishability, slightly magnetic. Machinable by grinding and with tungsten carbide tools.</p> <p>Hardness of pure weld deposit: 54 – 56 HRC            Hardness at 600°C: approx. 42 HRC            Hardness at 600°C: approx. 34 HRC</p>			
<b>Rod analysis in %</b>			
C	Cr	W	Co
2.3	32	13	balance
<b>Welding instruction</b>			
Clean welding area, preheating temperature 500-600°C, very slow cooling.			
<b>Welding procedure and availability</b>			
Ø x length	Current type		Shielding gas (EN ISO 14175)
3.2 x 1000 mm	DC (-)		I 1
Adjust acetylene excess (reducing flame) in oxyacetylene welding.			
<b>Approvals</b>			
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