

TH 806

TIG Welding Wire - Hardfacing Applications

Standards

AWS/ASME SFA - 5.21	ERCoCr-A
EN 14700	T Co2
TS EN 14700	T Co2
DIN 8555	WSG 20-GO-40-CTZ

Properties and Applications

Co-Cr-W alloy GTA (TIG) welding rod for hardfacing applications. Weld metal has got high resistance to metal-to-metal wear, corrosion and high temperatures from 500°C to 900°C. Due to weld metal toughness, it is resistant to mechanical and thermal shocks. Widely used for hardfacing of hot shearing blades, ingot tong ends, valves and valve seats, nozzles and glass dies.



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	W	Fe	Co
Welding Wire	1.00	1.00	0,50	28.00	2.00	5.00	2.50	60.00

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Hardness (HRc)
As welded	I1	40

* Chemical composition and mechanical properties are valid when using shielding gas EN ISO 14175 - I1 (%100 Ar) .

Application Information

Welding Positions

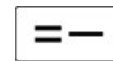


PA

PB

PC

Polarity:



Protection Gas:

I1

Welding Parameters & Efficiency

Diameter x Length (mm)
3.20x1000
4.00x1000
5.00x1000

Packaging Information

Product Code	Diameter x Length (mm)	Quantity per Box	Box Gross Weight (kg)	Boxes per Outer Box	Outer Box Gross Weight (kg)	Packaging Type
28102LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
28102MBKM2	4.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
28102NBKM2	5.00x1000	5 kg	5.30	4	21.40	Cardboard Tube

Storage & Re-Drying Information

Shouldn't be exposed to high statical load and impact.
It should be stored in a dry room (relative humidity < 50%, room temperature > 20°C) on wooden pallets.