

TH 812

TIG Welding Wire - Hardfacing Applications

Standards

AWS/ASME SFA - 5.21	ERCoCr-B
EN 14700	T Co3
TS EN 14700	T Co3
DIN 8555	WSG 20-GO-45-CTZ

Properties and Applications

Co-Cr-W alloy 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 tools for cutting and machining of paper, cardboard, floor coverings, roofing and wood, extrusion screws, glass dies.



Typical Chemical Features of the Welding Wire

Type of Analysis	C	Si	Mn	Cr	Ni	W	Fe	Co
Welding Wire	1.40	1.00	0.10	30.00	2.00	8.00	2.50	55.00

Typical Mechanical Values of Weld Metal

Test Condition	Protection Gas	Hardness (HRC)
As welded	I1	45

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

Application Information

Welding Positions

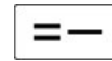


PA

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
28103LBKM2	3.20x1000	5 kg	5.30	4	21.40	Cardboard Tube
28103MBKM2	4.00x1000	5 kg	5.30	4	21.40	Cardboard Tube
28103NBKM2	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.