

AA CrCoMo-50

CATEGORY	FCAW Flux-Cored
TYPE	High-alloyed tubular wire on a C-Cr-Co basis for wear protection in several applications where metal to metal wear at high temperatures is needed. Weldable with shielding gas according EN 439: M11, M12 and M21
APPLICATIONS	Hot working tools such as: Dies and Continuous casting rollers.
PROPERTIES	Very good corrosion resistance and high hardness due to the amount of „Cobalt“ even at higher temperatures. Excellent weldability and often used as economical alternative for „stellite“ .

CLASSIFICATION	EN ISO 14700: no standard
	DIN 8555: MF 3-50-CKTZ

SUITABLE FOR	49-51 HRc hardfacing alloy containing Cobalt for excellent metal to metal wear, hot working tools, dies and continuous casting rollers.
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APPROVALS	CE approved
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WELDING POSITIONS:	
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WELD DEPOSIT WEIGHT %					
C	Mn	Si	Cr	Co	Mo
0.20	0.40	0.70	15.0	14.0	3.0

MECHANICAL PROPERTIES							
Heat Treatment	R _{p0,2} (N/mm ²)	R _m (N/mm ²)	A ₅ (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
							49-51

WELDING PARAMETERS / PACKING					
D (mm)	Welding Parameters			Packing	
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet
1.2	19-33	100-250	K-300 / Drum	15 / 250	1080 / 1000
1.6	19-33	160-320	K-300 / Drum	15 / 250	1000 / 1080
2.0	24-33	200-400	K-415 / Drum	25 / 250	950 / 1000
2.4	24-33	250-450	K-415 / Drum	25 / 250	950 / 1000

REDRYING TEMPERATURE	150°C / 24hr
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NOTE	Also available with less hardness of 47 HRc ▶ Ceweld AA CrCoMo-50L
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