

## AA CrCoMo 46

**CATEGORY** FCAW Flux-Cored

**TYPE** High-alloyed tubular wire on a Cr-Co-Mo basis for high temperature applications.

**APPLICATIONS** The characteristics of the deposit are comparable with cobalt-base alloys in terms of thermal shock and corrosion resistance that makes this alloy applicable for overlaying parts that are subject to high temperatures combined with corrosion attack, wear and thermal shock combinations. AA CrCoMo 46 can be used as intermediate layer against metal to metal wear at high pressure loads.

**PROPERTIES** Very good corrosion resistance combined with excellent hardness properties at temperatures up to 650°C. Scale resistant till 900°C and excellent strength at high working temperatures. Excellent weldability and often used as economical alternative for „stellite“

**CLASSIFICATION**

AWS	A 5.21:
EN ISO	14700: T Z Fe 3-45-CKTZ
DIN	8555: MF-3-45-CKTZ

**SUITABLE FOR** Hot rolling parts for continuous casting, hotpress tools, pump parts, sleeves, mandrels, forging hammers, chemical and glass industry.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**TYPICAL ALL WELD DEPOSIT WEIGHT %**

C	Si	Mn	Cr	Mo	Co	Ni	Fe
0.15	0.3	0.45	15.0	4.0	15.0	0.6	Rem

**MECHANICAL PROPERTIES OF THE PURE WELDING DEPOSIT**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V			Hardness HRc
				-20°C	-40°C	-60°C	
AW							44-48

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters			Packing		
	Voltage (V)	Current (A)	spool type	kg / spool	kg / pallet	
1.2	18-24	120-180	K-300 / Drum	15 / 250	1080 / 1000	
1.6	20-26	180-260	K-300 / Drum	15 / 250	1080 / 1000	

**REDRYING TEMPERATURE** 150°C / 24hr

**GAS ACC EN ISO 14175:** I1, (Argon + 1-2% O<sub>2</sub>)