

AX-Co1

Standards

DIN EN 14700:	R Co3
AWS A5.21:	ERCoCr-C

Properties

AX-Co1 is a tough, high-strength and heat-resistant Stellite® alloy for build-up welding with excellent resistance to metal-on-metal wear and abrasive wear stresses at high temperatures.

Due to the Cr and W carbides embedded in the cobalt base alloys, these alloys resist not only high abrasion but also strong corrosion attacks.

Important base materials / Important applications

Valve seats, palm nut oil presses, extruder screws, scrapers, grinding tools, pump sleeves, seals, rubber and plastic mixers.

Typical composition of welding rod / solid wire in %

C	Si	Mn	Cr	W	Fe	Co
2.3	1.1	0.2	31	12.7	2.4	Base

Mechanical properties of all-weld metal (typical values)

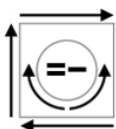
Hardness at 20°C	[HRc]	~ 53
Hardness at 800°C	[HB]	~ 220

Shielding gas: 100% Argon, PWHT: untreated

Operating data

TIG:

Shielding gas: I1 (100%Argon)
acc. to ISO 14175



Gas welding with oxygen-acetylene flame

Excess of acetylene (reducing flame)

Approvals

(Please ask for current scope)

Packaging and available sizes

Rods	Ø mm x 1000mm	2,7	3,2				
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Other dimensions on request.