

AI-1726

Specifications

DIN 8555 MF 20-GF-200-STZ

Description and Applications

Cobalt based MIG alloy providing excellent resistance to metal to metal wear, thermal shock, and oxidation in corrosive environments at high temperature. For reduced levels of dilution and improved weldability, it is recommended to use pulsed MIG welding mode. The deposit has the benefit of being machineable.

Applications include: hot working tools, forging hammers, ingot bloom and billet holders. As an underlay under harder cobalt based alloys.

Typical Weldmetal Analysis

C	Mn	Si	Cr	Ni	Fe	W	Co
0.01	0.8	0.4	20.2	2.20	3.5	13	Bal

Mechanical Properties of Weldmetal

	As Welded
Hardness	195HB as welded
Metal-to-metal wear resistance	Very good
Shock resistance	Excellent
High temperature resistance	Excellent
Thermal Shock Resistance	Exceptional
Machineability	Good
Deposit thickness	Depends on the application and procedure used
Flame cutting	Not possible
Shielding Gas	98% Ar + 2% O₂ or 100% Ar

Welding Parameters

Diameter (mm)	Current type	Amps
1.2	DC (+)	150-220
1.6	DC(+)	180-300

Welding Positions

(1G, 1F) Downhand/flat position, (2F) Horizontal position, (2G) Horizontal vertical position.

Disclaimer

All figures in this datasheet should be considered indicative only. No guarantee is made as to their accuracy.

All figures subject to change without notice. Batch analysis is available for all products sold. Should you require any further information, please contact us at sales@alloysint.com.au

