

## Classifications

<b>AWS A5.13 / SFA-5.13</b>	<b>DIN 8555</b>	<b>EN 14700</b>
E CoCr-C	E 20-UM-55 CSTZ	E Co3

## Characteristics and typical fields of application

WEARstick Co 1 is suited for highly wear resistant hardfacing on parts subject to severe abrasion in combination with corrosion and high temperatures up to 900 °C, such as working parts in the chemical industry, running and sealing faces on fittings, valve seats and cones for combustion engines, cutting and crushing tools, hot working tools exposed to severe stresses without thermal shock, milling, mixing and drilling tools.

Excellent gliding characteristics, good polishability, slightly magnetic.

Machining by grinding or with tungsten carbide cutting tools.

WEARstick Co 1 has excellent welding properties, a homogeneous, finely rippled seam due to spray arc and very easy slag removal.

Hardness of the pure weld deposit: 54 - 56 HRC

Hardness at 600 °C: approx. 42 HRC

Hardness at 800 °C: approx. 34 HRC

## Typical analysis

	C	Cr	W	Co
wt.-%	2.3	32	13	Bal.

## Operating data

	<b>Polarity</b>	DC + / AC	<b>Dimension mm</b>	<b>Current A</b>
			3.2 × 350	70 – 110
			4.0 × 350	90 – 130

## Welding instructions

Clean welding area, preheating temperature 500 – 600 °C, very slow cooling. Hold stick electrode vertically with a short arc and lowest possible amperage. Re-dry stick electrodes that have become damp for 2h/300 °C.

## Approvals

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