

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 _{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	
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% O₂)