

## SA CrCoMo-50 FCW

**CATEGORY** SAW Arc Submerged

**TYPE** High-alloyed tubular wire on a C-Cr-Co basis for wear protection in several applications where metal to metal wear at high temperatures is needed.

**APPLICATIONS** Hot working tools such as: Stamping dies and Continuous casting rollers.

**PROPERTIES** Very good corrosion resistance and high hardness due to the amount of „cobalt“ even at higher temperatures. High hardness achieved in the first layer and often used as economical alternative for „stellite“ . Best to be used with **FL 8111** welding flux.

**CLASSIFICATION** EN ISO 14700:  
DIN 8555: UP3-GF-50-CGRT

**SUITABLE FOR** Hot working tools such as: Stamping dies and Continuous casting rollers. Alternativ for stellite

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Si	Cr	Ni	Mo	Co
0.15	0.40	0.70	14.5	0.50	2.50	12.5

**MECHANICAL PROPERTIES**

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							45-52

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing	
	Voltage (V)	Current (A)	Spool type	kg / 6pack
2.4	26-30	200-450	Coil / Drum	25 / 330
2.8	28-32	250-500	Coil / Drum	25 / 330
3.2	28-32	300-550	Coil / Drum	25 / 330

**REDRYING TEMPERATURE** 150°C / 24hr