



Screw

Cobalt based Surfacing Alloy for Hot Abrasion & Corrosion Resistance

Typical Applications:

Steam, chemical valve seats & exhaust valves, Screw conveyors, Pump shafts, Dynamic parts subjected to corrosive gases and fluids, Hot shear & cutting blades, Banbury rotor.

Outstanding Features:

- Complex carbides in rich Alloy matrix.
- Resistance to softening at elevated temperatures.
- Retains hardness at 650 °C.
- Exceptional abrasion resistance due to high amount of carbides.
- High temperature impact & creep resistance properties.
- Hot cracking & fissuring resistance.
- Withstand combination of wear factors such as impact, abrasion, erosion, friction & heat.

Procedure:

Clean weld area by grinding and remove fatigued / damaged material. Remove sharp corners and edges. Preheating recommended for

complex shaped components, high carbon equivalent steels and low alloy steels. Buttering layer of NucleoTec 2222 on air-hardenable steels and Xyron 224 is recommended on cast iron before deposition of EWAC COB 6. This alloy can be applied directly on low carbon steels. Deposit stringer beads by holding electrode at 90 degree angle and maintain short arc length throughout the welding. Avoid weaving to minimize heat affected zone into the base metals. Clean each weld deposit with wire brush and no slag should be left on weld deposit. Use larger diameter electrode for overlay of thick section and smaller diameter electrode for edge build up applications. Cool slowly to room temperature.

Recommended Amperages:

Size(mm)	I-Range
3.15	70-110
4.00	90-130

Hardness: 35 - 45 HRc