



Screw

Cobalt base alloy with excellent wear resistance at elevated temperatures

Typical Applications:

Drill collars, chemical valve seats, pump sleeves, wear pads, screw conveyors.

Outstanding Features:

- Exceptional resistance to corrosion.
- Good all-round resistance to abrasion.
- Dense deposit with excellent weld quality.
- Super resistance to heat giving high hot hardness values.

Recommendation:

Cobalt alloy electrodes for producing excellent wear resistant overlays on carbon and alloy steels. Excellent results obtained even when high temperature service conditions prevail. Specifically provides ease of deposition and freedom from porosity, cracking and other faults common in products of this type.

Procedure:

Clean weld area. Remove fatigued or damaged metal with Eutec-ChamferTrode. Remove all sharp corners and projections. Grind all surfaces to remove oxides and other contaminants. Preheat if necessary for low carbon, air hardenable steels and cast iron. For cast iron cushion layer for Xyron 224 to be given. For air hardenable steel cushion layer of XHD 2222 to be given. Deposit the cobalt alloy. For low carbon steel the alloy can be deposited directly.

Recommended Amperages:

Size (mm)	I - Range
3.15	70 - 100
4.00	100 - 150
5.00	130 - 190

Hardness: 35 - 45 HRC (3 layer)