



Feed Screw

Cobalt based alloy having excellent resistance to heat, impact and abrasion.

Typical Applications:

Hot pressing dies, shear blades, hot cutting blades, hot hardness dies.

Outstanding Features:

- Exceptional resistance to heat with high hot hardness.
- Good all-round resistance to impact and abrasion.
- Dense deposit with excellent weld quality

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. Provides ease of deposition and freedom from porosity, cracking common in products of this type. Recommended for handling equipment for hot steel, dies etc.

Procedure:

Clean weld area. Remove fatigued or damaged metal with EWAC GOUGETRO. 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 ECAST 48. For air hardenable steel cushion layer of EHDP ROD D2. Then deposit the cobalt alloy. For low carbon steel the alloy can be deposited directly.

Recommended Amperages:

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

Hardness 40 - 52 HRC (3 layer)