Technical data sheet 011121MBA	Cored welding wire # STELLOY NI519Co2-G	Welding Alloys

CLASSIFICATION

EN 14700: T Ni4

DESCRIPTION

- Tubular metal-cored wire for gas shielded metal arc hardfacing
- Nickel-based superalloy designed to withstand extreme conditions
- The weld deposit resists high-temperature wear, heat up to 950°C, oxidation and thermal shock
- Hardenable by heat treatment and by cold work
- Machinable using carbide tools

APPLICATIONS

Suited for surfacing applications involving heavy mechanical stress with impacts and abrasion at high temperatures, particularly hot forging hammers or presses

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Mo	Co	W	Ti	Al	Fe	Ni
0.03	0.1	0.7	20	6	12	1	3	2	0.3	Bal.

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness (3-layer deposit)
As welded: 250 HB
After PWHT: 32 - 40 HRc

CONDITIONS OF USE

Current type	Gas (EN ISO 14175)	Gas flow rate	Recovery
DC+	I1 (Argon)	15 - 20 l/min.	97 %

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	350-500	450	26 - 30	28	20-30	25

WELDING POSITIONS

Flat, half up, half down, all positions

PACKAGING

Diameter	≤ 2.4 mm	≥ 2.4 mm	
Standard packaging	EN ISO 544: BS 300 spool	B 450 coil	Drum
Weight	15 kg	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us