

Technical data sheet

EN030524GB

Cored welding wire

HARDFACE DCO-O**CLASSIFICATION**

EN 14700: T Z Fe3

DESCRIPTION

- Cored wire for self shielded arc welding
- Special martensitic alloyed steel offering similar performance to cobalt based alloys
- The Fe-Cr-Co-Mo welding deposit is especially suited to resist metal-to-metal wear, oxidation, and corrosion at temperatures up to 600 °C
- Economic alternative to cobalt based alloys

APPLICATIONS

HARDFACE DCO-O is used for surfacing of hot working stamping punches, dies, casting rollers, ect.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	Ni	Mo	Co	Fe
0.15	0.5	0.8	13.5	0.6	3.0	13.0	Bal.

Structure: highly alloyed martensite

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES**Hardness:**

As welded, 3-layer on mild steel: 45 - 52 HRC

Tensile:

Ultimate Tensile Strength: 1450 MPa

CONDITIONS OF USE

Current type	Protection
DC+	Self-shielded

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
1.6	150 - 350	270	25 - 35	28	20 - 30	25
2.0	200 - 400	300	25 - 35	28	30 - 40	35
2.4	250 - 450	350	25 - 35	28	35 - 45	40

Recovery: 90%

WELDING POSITIONS

Flat

PACKAGING

Diameter	1.6 - 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

Welding products and techniques evolve constantly. All descriptions, illustrations and properties given in this data sheet are subject to change without notice and can only be considered as suitable for general guidance. This document is intended to help the user make the correct choice of product. It is his responsibility to assess its suitability for his intended application.