Technical data sheet EN030524GB	Cored welding wire # HARDFACE DCO-S	Welding Alloys

CLASSIFICATION

EN 14700: T Z Fe3

DESCRIPTION

- Cored wire for submerged 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
- Crack free deposit, high hardness achieved from the first layer
- Economic alternative to cobalt based alloys

APPLICATIONS

HARDFACE DCO-S 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

FLUX DESCRIPTION

	WA FLUX 325	WA FLUX 385	WA FLUX 415	WA ULTRAFLUX
EN ISO 14174 class	S A AB 1 65	S A AF 2 64	S A FB 1 55	S A FB 1 55

OPERATING CONDITIONS

Diameter [mm]	Current [A]		Voltage [V]		Stick-out [mm]	
	Range	Optimum	Range	Optimum	Range	Optimum
2.4	250 - 450	350	25 - 35	30	25 - 35	30
2.8	300 - 500	400	25 - 35	30	25 - 35	30
3.2	350 - 550	450	25 - 35	30	25 - 35	30

Recovery : 95 %

Current type/polarity: DC+

WELDING POSITIONS

Flat

PACKAGING

Diameter	2.4 - 3.2 mm	
Standard packaging (EN ISO 544)	B 450 coil	Drum
Weight	25 kg	Up to 330 kg

Other packaging and other diameters: please consult us