

Classifications

TIG rod

EN 14700	DIN 8555	AWS A 5.21
R Co3	WSG 20-GO-50-CSTZ	~ER CoCr-B

Characteristics and field of use

UTP A CELSIT 712 SN is suitable for highly wear resistant hardfacing of parts subject to a combination of abrasion, erosion, corrosion, cavitation, pressure and high temperatures up to 900 °C, such as sealing and gliding surfaces of fittings and pumps, valve seats and cones for combustion engines, tools for wood, paper and plastic industries, gliding surfaces metal to metal, milling, mixing and drilling tools, heavy-duty hot work tools without thermal shock.

Excellent gliding characteristics, good polishability, non-magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of pure weld deposit: 48 – 50 HRC

Hardness at 500 °C: approx. 40 HRC

Typical analysis of rod and wire in %

C	Cr	W	Co
1.8	29.0	8.5	balance

Welding instructions

Clean welding area, preheating temperature 500 – 600 °C, very slow cooling.

Form of delivery and recommended welding parameters

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
3.2 x 1000 mm	DC (-)	I 1
4.0 x 1000 mm	DC (-)	I 1
5.0 x 1000 mm*	DC (-)	I 1

Adjust acetylene excess (reducing flame) in oxyacetylene welding.

* Available on demand.