

COROLOY CO

Suitable for steel that encounters aggressive corrosive media as well as those steels that operate at high temperatures, COROLOY Co is the high alloyed Cr- Mo- Co- W- flux cored Nickel based wire solution. This alloy is This hardfacing alloy is extraordinarily resistant on impact, pressure loads and high temperature environments, which results in hardening of the

deposit up to a hardness of about 420 HB with little deformation. When build-up layers are required, CORODUR® 200 K is recommended as a buffer layer. It is also recommended that the base material should be preheated to about 300 °C – 400 °C before hardfacing. For multi-layer welding low inter-pass temperature and low energy input is recommended.



Hot forging dies, forging plant parts, hot shear blades, hammer and hammer-saddles, repair of injection moulding castings, piercing mandrels, buffering alloy for forging hammer-saddles and hammers.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Ni

C	Cr	Mo	Co	V	W	Fe
0,08	16,0	16,0	2,5	0,35	4,5	< 5,0

Hardness HB	260-280	bis ca. 420 hardenend	ca. 430 hardenend 900 °C/air	Elongation ca. 20%
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PARAMETER

Diameter	Voltage	Amps
1,6	22-26	180-240
2,0	25-27	220-260
2,4	25-27	260-300
2,8	26-28	280-340

Other Dimensions on demand

FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded , SA = Submerged Arc