



DAIKOFCW 1025



COBALT ALLOYS
Gr. 25

DESCRIPTION

Cobalt based cored wire for hardfacing

This flux cored wire deposits a cobalt-based alloy, with the addition of chromium, tungsten and nickel to achieve excellent resistance to high temperatures and oxidation as well as sulphiting. It can be used in high temperature oxidizing environments, with operating temperatures up to 1093°C. The material also has good wear and abrasion resistance. This combination of characteristics makes this wire the ideal material for applications in the aeronautical and aerospace sectors, but also for land-based gas turbines.

SPECIFICATIONS

ISO 14700	T Co1	AWS	-
DIN	-	Werkstoff Number	-
Certifications	-	Shielding	I1, I3
Positions	PA, PB, PC	Current	DC+

ASME QUALIFICATIONS

F-No (QW432)	-	-	-	23HRC - 40HRC
A-No (QW442)	-	-	-	

CHEM. COMP. %

DEFAULT

C	0.25
Mn	0.1
Ni	10
Cr	20.5
Si	0.5
Fe	15
W	15

MECHANICAL PROPERTIES

	MIN	VARIANT
Tensile strength R _m MPa	-	-
Yield strength R _{p0.2} MPa	-	-
Elongation A (L ₀ =5d ₀) %	-	-
Impact Charpy ISO-V	-	-
Impact Charpy ISO-V	-	-

WELDING PARAMETERS

	1.2 mm	1.6 mm
Ampere	100A - 250A	140A - 350A
Voltage	16V - 29V	26V - 30V
Packaging	Ø 1,2÷1,6mm	Ø 1,2÷1,6mm
Packaging Type	BS300 spool	BS300 spool

ANTI-WEAR CHARACTERISTICS

Adhesive wear	▲ ▲ ▲ ▲ ▲
Abrasive wear	▲ ▲ ▲ ▲ ▲
Impact	▲ ▲ ▲ ▲ ▲
Corrosion	▲ ▲ ▲ ▲ ▲
Heat	▲ ▲ ▲ ▲ ▲

V 01/2024



The information in this datasheet is the result of detailed research and is considered accurate as of the publication date. However, we cannot guarantee its complete accuracy, and it is subject to change without notice. Actual results may vary due to many factors like welding procedures, material composition, temperature conditions, bevel configuration, and specific manufacturing techniques. We accept no liability for any errors or omissions in this datasheet. For the most current information, please visit www.daikowelding.com.





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APPLICATION

This filler, derived from the L605 rolled alloy, excels in resisting thermal fatigue. It is used to rebuild tools for hot steel operations like scissors and punches in the steel industry. The non-magnetic weld metal showcases robust mechanical strength and effective oxidation resistance up to 980°C. It resists sulphuration and wear in metal-to-metal bonds, providing reliable "metal-to-metal" resilience against corrosion, abrasion, cavitation, and high impacts, especially at elevated temperatures. It endures in oxidizing and reducing atmospheres, up to 1150°C. Widely applied in molding and die applications for hot forming, it finds versatile use in the petrochemical industry, high-pressure steam control valves, various valves, shear blades, turbine blade recharging, extrusion dies, forging dies and tools, furnace components, and tools designed for working hot steel.

ALLOY TYPE

Cobalt-based alloy with additions of chromium, tungsten and nickel for excellent high temperature strength and oxidation resistance

MICROSTRUCTURE

Chromium and tungsten carbides in an austenitic type matrix.

MATERIALS

It is used for rebuilding and/or hardfacing of tools that work hot steel, such as scissors, punches, etc. for the steel industry.

WELDING & PWHT

Prior to welding, ensure a thorough cleaning of the joint surface and surrounding area to remove contaminants like grease, oil, crayon marks, sulfur compounds, and foreign matter. Avoid any contact between the joint area and copper or copper-bearing materials. While it's preferable for the alloy to be in a solution-annealed condition during welding, preheating is generally unnecessary as long as the base metal temperature stays above 0°C. Maintain low interpass temperatures during welding. For multiple weld passes, use auxiliary cooling methods if needed, ensuring they don't introduce contaminants. Post-weld heat treatment is usually unnecessary under normal conditions.

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