

Classifications

TIG rod

EN 14700

DIN 8555

AWS A 5.21

R Z Co2

WSG 20-GO-40-CSTZ

ER CoCr-A

Characteristics and field of use

UTP A CELSIT 706 V is suitable for hardfacing of parts subject to a combination of erosion, corrosion, cavitation, pressure, impact, abrasion and high heat up to 900 °C, such as tight surfaces of fittings, valve seats and cones for combustion engines, gliding surfaces metal to metal, highly stressed hot working tools without thermal shock, milling, mixing and drilling tools.

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

Hardness of pure weld deposit: 40 – 42 HRC

Hardness at 500 °C: approx. 33 HRC

Typical analysis of rod and wire in %

C	Cr	W	Co
1.2	27.0	4.5	balance

Welding instructions

Clean welding area, preheating temperature 450 – 600 °C, very slow cooling.

Form of delivery and recommended welding parameters

<i>Rod diameter x length [mm]</i>	<i>Current type</i>	<i>Shielding gas (EN ISO 14175)</i>
2.4 x 1000 mm*	DC (-)	I 1
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.