









CEWELD ULTIMET Alloy Tig

TYPE	Cobalt-based solid welding wire for hardfacing / rebuilding																				
APPLICATIONS	Wire can be used to weld ULTIMET wrought products and to overlay and clad carbon and low-alloy steels. The weld deposits harden very quickly by cold working. In addition, it is very easy to deposit a "crack-free" layer without a butter layer. The filler metal finish on the MIG wire is for a smooth feeding through welding equipment and reduces tip wear in contact tips.																				
PROPERTIES	-ULTIMET wires easily produces crack-free weld deposits (over-matching weld overlays, weld inlays, and claddings). -It is easier tot weld with ULTIMET wire than traditional cobalt-based alloys, allowing multiple layer build-ups with no pre-heating needed. -ULTIMET wire produces deposits wich harden quickly through peening, machining, power hammering, burnishing, or hard particle impingement. This hardness creates a tough, ductile, wear-, corrosion-, and high-temperature resistant surface. The hardness of 30% cold-worked wrought product is approximately RC50. - ULTIMET deposits exhibit extremely high resistance to metal to metal galling and seizing. -The pitting resistance of ULTIMET alloy in chloride solutions is equal to that of HASTELLOY C-22HS alloy, and is greater than that of C-276 alloy.																				
CLASSIFICATION																					
SUITABLE FOR	•Valve component overlay •"Make/break" seal welds in threades unions •Weld overlays to marine riser tensioners, shafts, and larger hydraulic systems pistons •Weld overlay to u-bends, piping and valves used in conveying sour crudes containing abrasives •Slurry, rock, and acid tumblers & mixers •Impellers •Fiberglass manufacturing																				
APPROVALS	No Approvals Found																				
WELDING POSITIONS	<div>PAPBPCPDPEPF</div>																				
TYPICAL CHEMICAL ANALYSIS OF THE FILLER METAL (%)	<table><tr><td>Co</td><td>Cr</td><td>Ni</td><td>Mo</td><td>Fe</td><td>W</td><td>Mn</td><td>Si</td><td>N</td><td>C</td></tr><tr><td>Rem.</td><td>26</td><td>10</td><td>5</td><td>3</td><td>2</td><td>0.5</td><td>0.08</td><td>0.08</td><td>0.08</td></tr></table>	Co	Cr	Ni	Mo	Fe	W	Mn	Si	N	C	Rem.	26	10	5	3	2	0.5	0.08	0.08	0.08
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ALL WELD MECHANICAL PROPERTIES	<table><tr><td>Heat Treatment</td><td>R_{p0,2} MPa</td><td>R_m MPa</td><td>A5 (%)</td></tr><tr><td>As Welded /</td><td></td><td>917</td><td>13</td></tr></table>	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	As Welded /		917	13												
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REDRYING TEMPERATURE	Not required																				
GAS ACCORDING EN 14175	I1																				



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 **certilas**® THE FILLER METAL SPECIALIST

ULTIMET ALLOY TIG 0,9 X
914MM

Type	KG/unit	EANCode
	0,91	8720663420183

ULTIMET ALLOY TIG 2,4 X
914MM

Type	KG/unit	EANCode
	4,54	8720663420190