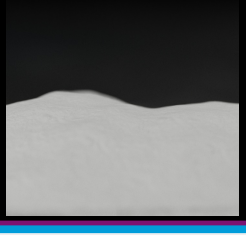

CEWELD Powder PTA DUR 12

certilas® THE FILLER METAL SPECIALIST

TYPE

Gas atomized spherical Cobalt-Chromium-Tungsten alloy powder. (P Co3, Stelitte 12)

APPLICATIONS

CEWELD Powder PTA DUR 12 is a cobalt-base metallic powder with spherical shape designed for plasma-transferred-arc (PTA) welding process. It is especially suited for hardsurfacing of parts subject to a combination of erosion, corrosion, cavitation, pressure, impact and abrasion and high temperatures.
Such as: Internal combustion exhaust valve, Valve plugs & seats, Pump sleeves, Bearing areas, Saw blades and tips, Saw teeth, Chain saw guide bars, and other Wood cutting tools, Knives, Scissor blades, Molten glass cutter
Twist rolls, Hot extrusion dies

PROPERTIES

CEWELD Powder PTA DUR 12 weld deposit can be machined with tungsten tool tips and by grinding. It have a Excellent gliding and abrasion characteristics, very good polishability, normalized in hardness, slight-magnetic. Machinable by grinding and tungsten carbide tools.
Melting temperature: 1200 – 1365 °C Density: 8.5 g/cm^3
Hardness of the weld deposit (approx.) approx. 50 HRC in the second layer welded by PTA process Hot hardness at 500 °C (approx.) approx. 42 HRC in the second layer welded by PTA process

CLASSIFICATION

EN ISO 14700: P Z Co3

SUITABLE FOR

CEWELD Powder PTA DUR 12 is a cobalt-base metallic powder with spherical shape designed for plasma-transferred-arc (PTA) welding process.

APPROVALS

No Approvals Found

WELDING POSITIONS

TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

Co	C	Si	Cr	W	Fe	Ni	Mo
Rem.	1.5	1.1	30	9	1.4	2	0.9

ALL WELD MECHANICAL PROPERTIES

Heat Treatment	$R_{P0,2}$ MPa	Rm MPa	A5 (%)		Hardness Rockwell C
As Welded /					Avg. 48

REDRYING TEMPERATURE

Not required

GAS ACCORDING EN 14175