

COR™BALT 1 FC

DESCRIPTION

COR™BALT 1 FC is a flux-cored, cobalt base wear facing alloy designed for maximum abrasion, corrosion, and heat resistance. Tungsten, coupled with chromium carbides allows 1 FC to resist galling and oxidation, and to maintain an effective hardness at operating temperatures up to 1300°F. Deposits also have a low coefficient of friction, and consequently develop a high polish in service.

APPLICATIONS

Typical wearfacing uses include: cement plant machinery, steel plant equipment, metal working tools, coke pusher shoes, carbon scrapers, and rubber mixing equipment.

PROCEDURE

A minimum preheat of 350°F is recommended for mild steels. Preheat all other alloys according to the base material.

WELDING PARAMETERS

| Size | Volts | Amps | Stickout | Shield Gas/Flux |
|------------|-------|---------|----------|--|
| MC-G .045" | 16-30 | 120-250 | 1/2" | CO ₂ or Ar-CO ₂ mixtures |
| MC-G 1/16" | 18-30 | 150-250 | 1/2" | CO ₂ or Ar-CO ₂ mixtures |
| FC-O 1/16" | 24-28 | 200-300 | 1 1/4" | none |
| FC-O 3/32" | 24-28 | 250-350 | 1 1/2" | none |
| FC-S 3/32" | 27-29 | 325-375 | 1" | Lincoln 880 |

MECHANICAL PROPERTIES

Hardness: 50-55 Rc as welded

CLASSIFICATION

AWS A5.21, ERCCoCr-C