

COR™BALT 21 ELECTRODE

DESCRIPTION

COR™BALT 21 is a cobalt base electrode designed for resistance to impact, thermal fatigue, and corrosion at temperatures up to 1500°F. 21 is not used for severe abrasion applications, but the weld deposit exhibits superior resistance to heat checking, spalling, chipping, and erosion.

APPLICATIONS

Typical hot work applications include: impressions in forging dies, trimming dies, high temperature valves, punches, shear blades, and extrusion dies. 21 is also used to overlay parts subject to oxidizing and reducing atmospheres at temperatures up to 2100°F.

PROCEDURE

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

WELDING PARAMETERS

Size	5/32"	3/16"
Amps	140-160	180-200

MECHANICAL PROPERTIES

30-35 Rc as welded, 40+ Rc work hardened

CLASSIFICATION

Comparable to AMS 5385

TIG

This alloy is also available in solid rods for TIG welding. The properties and applications are the same as shown above. When ordering it for TIG the designation is 21 SWT. SWT stands for "solid wire tig". The standard length of the TIG rods is 14". Use standard tig methods for application with 100% Argon shielding gas.