

CEWELD AA DUR 1

TYPE Cobalt-based fluxcored wire with high abrasion and corrosion resistance. (Stellite 1)

APPLICATIONS **CEWELD AA DUR 1** is for highly wear resistant hardfacing combination abrasion, erosion, corrosion, cavitation, pressure and high temperatures up to 1000°C, such as working parts in the chemical industry, running and sealing surfaces of fittings, valve seats and cones for combustion engines, cutting and shredding tools, heavy-duty hot working tools without thermal shock, milling, mixing and drilling tools Pump sleeves, expeller screws, plastic recycling, mixer blades for rubber, valves, seats etc..

PROPERTIES **CEWELD AA DUR 1** deposits a cobalt-base alloy with an austenitic-ledeburitic structure. This is the hardest of the standard cobalt-base alloys. It has a high resistance to corrosion (especially to reducing acids and impact), extreme wear and temperature shocks. The alloy is only machinable by grinding. Best used on wear pads, rotary seal rings, pump sleeves and centerless grinder work rests. Excellent gliding characteristics,

CLASSIFICATION

AWS	A 5.21: ERCCoCr-C
EN ISO	14700: T Co3
DIN	8555: MSG 20-GF-55-CTZ
F-nr	71

SUITABLE FOR ER CoCr-C / Co3
Stellite 1

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

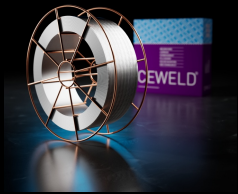
C	Si	Mn	Cr	Mo	Fe	W	Co
2.5	1	0.1	29	0.002	3	11	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{p0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				53 HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M13



CEWELD AA DUR 1

AA DUR 1 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663401991
BS-300	15	8720663402004