DMCCO#12 -- DURAMAX COBALT #12 -- TUBULAR CORED WIRE

Classification: **ERCCoCr-B** ***Specification:*** AWS A5.21 / ASME SFA 5.21

Description:

DMCCO#12 is a tubular fabricated wire version of the cobalt alloy produces a high hardness cobalt-chromium deposit for high temperature applications with good abrasive wear associated with corrosion. Chromium carbides contained in deposit provides excellent resistance to many forms of chemical and mechanical degradation, including galling. It bonds well with all weldable steels including stainless.

DMCCO#12 valve and pump parts, chain saw bars & teeth, aircraft turbine blades, cutter rolls.

Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Fe	W	Co
1.2 - 2.0	2.0 max	2.0 max	25.0 - 32.0	3.0 max	1.0 max	5.0 max	7.0 - 10.0	Remainder
TOE = 1.0 max								

Typical Deposit Characteristics:

- Metal to Metal Wear	Excellent	- Cold Abrasion	Excellent
- Impact Resistance	Good	- Hot Abrasion	Excellent
- Erosion	Excellent	- Deposit Layers	2 Layers
- Corrosion	Excellent	- Machinability	Use Carbide Tools
- Hardness	HRC 34 - 51	*With Proper Preheat and Slow Cooling	

Sizes available and recommended currents

Diameter	Amps DCEP	Voltage	Shielding Gas	Wire Extension	Position
.045" (1.2mm)	180 - 200	25 - 27	Argon	1/2" - 5/8"	Flat
1/16" (1.6mm)	280 - 300	26 - 28	Argon	5/8" - 3/4"	Flat