

# GETIG ST-1

## IDENTIFICATION

Getig ST-1, ERCoCr-C

## CLASSIFICATION

AWS/SFA 5.21: ER CoCr-C

## DESCRIPTION

ERCoCr-C-alloyed welding wire for TIG and oxy-acetylene welding.

## CHEMICAL ANALYSIS (RANGE) %

C	Cr	W	Mo	Mn	Si	Ni	Fe	Co
2.0-3.0	26-33	Nov-14	1.0 max	1.0 max	2.0 max	3.0 max	3.0 max	Bal

## TYPICAL APPLICATIONS

- Seal Rings,
- Cutters,
- Chain Saws,
- Crushers

## WELDING INSTRUCTIONS

Clean welding area, preheating temperature 450 - 600°C. Very slow cooling.

**HARDNESS OF THE PURE WELD DEPOSIT** : 46 HRC approx.

**CURRENT TYPE** : DC (-)

**SHIELDING GAS** : Pure Argon, For oxy-acetylene welding use acetylene excess (reducing flame).

## PACKING PARAMETERS

Size (mm)	Length (mm)	Packing / Pkt (Kg)	Packing / Box (kg)
3.15 / 3.20	1000	5	5 x 4 = 20
4	1000	5	5 x 4 = 20
4.8	1000	5	5 x 4 = 20
5	1000	5	5 x 4 = 20