

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