

GETIG ST12

IDENTIFICATION

Getig ST-12, ERCoCr-B

CLASSIFICATION

AWS/SFA 5.21: ER CoCr-B,
DIN 8555: G/WSG 20-GO-40-CTZ

DESCRIPTION

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

CHEMICAL ANALYSIS (RANGE) %

| C | Cr | W | Mn | Si | Ni | Mo | Fe | Co |
|---------|-------|---------|---------|---------|---------|---------|---------|---------|
| 1.2-1.7 | 26-32 | 7.0-9.5 | 1.0 max | 2.0 max | 3.0 max | 1.0 max | 3.0 max | Balance |

TYPICAL APPLICATIONS

- GETIG ST12 is suitable for hard facing of parts subjected to a combination of pressure, impact, abrasion, corrosion, erosion, cavitations and high heat up to 900°C, such as tight surfaces of fittings, valve seats and cones for combustion engines, gliding surfaces metal to metal, highly stressed hot working tools without thermal shock, milling, mixing and drilling tools.
- Excellent gliding characteristics, very good polish ability, high toughness, non-magnetic.
- Machinable by grinding and with tungsten carbide tools.

WELDING INSTRUCTIONS

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

HARDNESS OF THE PURE WELD DEPOSIT : 46-48 HRC

HARDNESS AT 600°C : 40 HRC

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 |