

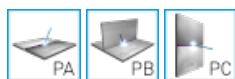


# CEWELD E DUR 25U

|                |                                                                                                                                                                                                                                               |
|----------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| TYPE           | Cobalt-based thermo shock resistant alloy for overlay applications. ( E Z Co1, Dur 25 )                                                                                                                                                       |
| APPLICATIONS   | Cladding valve seats, Gasturbine components. Metal working tools like piercing points, forming tools and extrusion dies that are exposed to metal on metal wear in combination with thermal fatigue. Also furnace hardware                    |
| PROPERTIES     | CEWELD E DUR 25U is a Cobalt based electrode developed to resist high impact load, high heat, thermal shock, hot corrosion, compression, abrasion, erosion and many other forms of attack. The weld deposit is machinable with carbide tools. |
| CLASSIFICATION | EN ISO 14700: ~E Co1<br>DIN 8555: E 20-UM-300- CTZ                                                                                                                                                                                            |
| SUITABLE FOR   | Valves in chemical and steam plants, Gasturbine components, Tong bits, Share blades, Hot forging and stamping tools, Hot dies, Aerospace industry, Turbo charger buckets, Hot liquid pumps etc.                                               |

## APPROVALS

## WELDING POSITIONS



## TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

| C   | Mn | Cr | Ni | Mo | Fe | W  | Co   |
|-----|----|----|----|----|----|----|------|
| 0.1 | 2  | 20 | 10 | 1  | 3  | 15 | Rem. |

## MECHANICAL PROPERTIES

| Heat Treatment | R <sub>P0.2</sub> (MPa) | R <sub>m</sub> (MPa) | A <sub>5</sub> (%) | Hardness |
|----------------|-------------------------|----------------------|--------------------|----------|
| As Welded      |                         |                      |                    | 25 HRc   |

REDRYING Not required

GAS ACC. EN ISO 14175