

CEWELD Powder PTA DUR 12

TYPE	Gas atomized spherical Cobalt-Chromium-Tungsten alloy powder. (P Co3, Stellite 12)																
TOEPASSINGEN	CEWELD Powder PTA DUR 12 is a cobalt-base metallic powder with spherical shape designed for plasma-transferred-arc (PTA) welding process. It is especially suited for hardsurfacing of parts subject to a combination of erosion, corrosion, cavitation, pressure, impact and abrasion and high temperatures. Such as: Internal combustion exhaust valve, Valve plugs & seats, Pump sleeves, Bearing areas, Saw blades and tips, Saw teeth, Chain saw guide bars, and other Wood cutting tools, Knives, Scissor blades, Molten glass cutter Twist rolls, Hot extrusion dies																
EIGENSCHAPPEN	CEWELD Powder PTA DUR 12 weld deposit can be machined with tungsten tool tips and by grinding. It have a Excellent gliding and abrasion characteristics, very good polishability, normalized in hardness, slight-magnetic. Machinable by grinding and tungsten carbide tools. Melting temperature: 1200 – 1365 °C Density: 8.5 g/cm ³ Hardness of the weld deposit (approx.) approx. 50 HRC in the second layer welded by PTA process Hot hardness at 500 °C (approx.) approx. 42 HRC in the second layer welded by PTA process																
CLASSIFICATIE	EN ISO 14700: P Z Co3																
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GOEDKEURINGEN																	
LASPOSITIES																	
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><thead><tr><th>Co</th><th>C</th><th>Si</th><th>Cr</th><th>W</th><th>Fe</th><th>Ni</th><th>Mo</th></tr></thead><tbody><tr><td>Rem.</td><td>1.5</td><td>1.1</td><td>30</td><td>9</td><td>1.4</td><td>2</td><td>0.9</td></tr></tbody></table>	Co	C	Si	Cr	W	Fe	Ni	Mo	Rem.	1.5	1.1	30	9	1.4	2	0.9
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HERDROGEN	Not required																
GAS ACC. EN ISO 14175																	