CARBO TS 21

Standards	DIN 8555	W / SG 20--300-CKTZ

Approvals ---

Characteristics

CARBO TS 21 is a bare rod for the TIG welding process.
The deposit is a cobalt base alloy of high tenacity as well as extreme corrosion- and heat resistance.
The weld metal is highly resistant to impact and is work-hardening up to 45 HRC.
Working temperature should be kept between 400° and 600°C, depending on base material and type of construction. Slow cooling, if necessary oven cooling, is recommended for low alloyed and austenitic steels.
Subsequent heat treatment (stress relief at 700°C approx.) is not necessary, except on large structures.

Operating temperature From room temperature up to + 300° C

Typical applications

Due to its above-mentioned characteristics CARBO SK 21 is particularly recommended for use on all work pieces which are subject to corrosion, impact wear as well as high temperatures or thermal shocks.

Hardness of all-weld metal
(typical values **)**

At Rt. HRC	+ 300°C HB	work hardened HRC	Melting-point	Density g/cm³
ca. 30	ca. 280	ca. 280	1250°C	8,3

Weld metal analysis
(typical, wt. %)

C	Si	Mn	Cr	Mo	Ni	Co	Fe
0,3	0,9	1	28	5,5	3	Base	3

Current = -

Welding positions PA, PB, PC , PD, PE, PF

Gas types EN 439 **I 1: Argon**

Flux-cored wire equivalent CARBO F- S 21

Dia./Length	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	333	1333	15,0	5,0	20,0
3,2 x 350	200	800	25,0	5,0	20,0
4,0 x 350	147	588	34,0	5,0	20,0
5,0 x 350	91	363	78,7	5,0	20,0