

COROLOY 520 W

COROLOY 520 W deposits a Cr-Co-Mo-Ti-Al-W- alloy in a nickel base. The weld metal is a precipitated, easily hardened alloy with an exceptional combination of high temperature mechanical properties, formability and corrosion resistance. The alloy can be used for hot forging

dies, hot working steels, hot shear blades, etc.. To obtain a crack-free weld, the base material should be preheated to 350 °C and held. After the weld is completed, the cooling rate should be low.



Hot forging hammers, hot forging dies, pilger rolls, mandrels, highly heat resistant impact loaded claddings, repairs on CrMoNi alloys.

TYPICAL ALL WELD METAL ANALYSIS (%)

Base = Ni

C	Cr	Mo	Co	W	Ti	Al
0,05	20	6,0	10,0	4,0	3,0	2,0

Hardness HRC

32 - 35

bis 45 HRC
hardenend

PARAMETER

Diameter	Voltage	Amps
1,6	23-26	180-260
2,0	24-27	240-280
2,4	25-27	280-340
2,8	25-28	320-400

Other Dimensions on demand

FORMS OF DELIVERY

Unit	Weight
Coil BS 300	15 kg
Coil B 450	25 kg
Drums	300 kg

G = Gas shielded , SA = Submerged Arc