

# CARBALOY 22

## ULTRA HIGH TEMPERATURE AND CORROSION RESISTANT COBALT ALLOY

### AC OR DC EITHER POLARITY

### GENERAL CHARACTERISTICS:

Smooth running, high deposition electrode for high temperature, corrosion, and thermal shock applications. Resists cracking from impact and thermal stress. Superior hot abrasion resistance.

### APPLICATIONS:

Rebuild hot forging dies, trimming dies, valve seats, hot shears blades, punches, and other hot working tools subjected to impact, abrasion, and thermal shock.

### TECHNICAL DATA:

Hardness as welded .....	28-36 Rc
work hardened .....	45-50 Rc
Tensile Strength.....	up to 135,000 psi (930 N/mm <sup>2</sup> )
Current .....	AC or DC either polarity
Amperage 60-90 80-120 110-170 160-250	
(in) 3/32" 1/8" 5/32" 3/16"	
(mm) 2.5 3.25 4.0 5.0	

### PROCEDURE:

Surface to be welded must be clean and free of cracks. Preheat to 200°F-650°F (93°C-350°C). Maintain medium long arc length, use stringer beads or very narrow weave and hold electrode perpendicular to work. Allow parts to cool slowly after welding. Work hardening prior to being placed in service can be accomplished by cold working (peening).

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EXTREME DUTY CARBALOY 22