

CARBO SK 21

Standards

DIN 8555	E 20-UM-300-CKTZ
----------	------------------

Approvals ---

Characteristics CARBO SK 21 is a rutile coated electrode which is AC weldable. 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.	+ 300°C	work hardened	Melting-point	Density
	HRC	HB	HRC	°C	g/cm ³
	ca. 30	ca. 280	ca. 45	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 = + / ~ 42 V

Welding positions PA, PB, PC

Rebaking 1 h, 350 + / - 10 °C (if required)

Flux-cored wire equivalent

CARBO F- S 21

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	kg/1000	kg/packet	kg/carton
2,5 x 350	40 - 75	235	939	21,3	5,0	20,0
3,2 x 350	70 - 110	140	560	35,7	5,0	20,0
4,0 x 350	100 - 140	103	412	48,6	5,0	20,0
5,0 x 350	140 - 180	64	254	78,7	5,0	20,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.