

GOLD 1045-E (770) FOR METAL/METAL WEAR

Description and Applications:

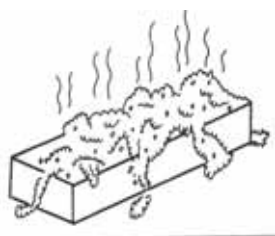
Electrode with a **complex Co-Cr composition alloyed with W** for surfacing of parts which are subjected to a combination of metal/metal wear, corrosion and heat up to 800°C and shortly up to 1000°C.

Use for protection and repairs on valve seats, bushings, bearings, hot shear knives, moulds, mixer blades, screws, knives pump sleeves.

- exceptional resistance to corrosion and heat
- deposits are free from cracks or porosity
- high hot hardness values
- **Weld deposit:** Cobalt base, tungsten, chrome, iron



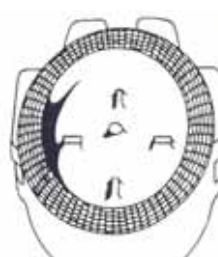
Hot work tools and dies



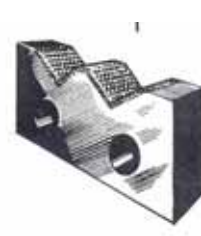
For high corrosion



Resist high temperature



For valve seats



Hot shear blades/

Mechanical properties

Hardness :

42 to 45 HRC at 20 C
30 HRC at 600°C

Packaging Data

Sizes	2.5x300	3.2x350	4.0x350
Kgs/Packet	4	4,5	4,5
Packets/carton	4	4	4
Kgs/carton	16	18	18

Welding instructions

Current (A)	75	110	140	
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1G/PA



2F/PB



2G/PC

= + ~ 70V

Clean area to be overlaid. Remove old hard facing and fatigue metal by gouging with gold 110 and grinding.

Preheat according to base metal. Select recommended amperage..

Deposit electrode with stringer or weaving beads and use short arc, avoid excessive weaving.

On hard steels apply buffer layer of 330 or 510. on cast iron use buffer layer of gold 420. On low carbon steel Gold 1045 can be applied directly.