

SUNALLOY 627 B

Special cobalt based alloy for surfacing plain carbon and alloy steels



DESCRIPTION

A versatile cobalt-containing alloy with high impact resistance. It is used primarily on work pieces exposed to high alternating temperatures and corrosion.

ALLOY BASIS

Co, Cr, W, Ni

PROPERTIES

SUNALLOY 627 B is wear facing electrode with cobalt based alloy (satellite) to retain hardness even at high temperatures. Has high resistance to corrosion, oxidation, heat and impact.

APPLICATIONS

Valves and valve seats, sealing surfaces, hot shear blades, hot pressing tools, forging deburrers, wire mill rolls and beaters for coke comminution. Surfacing of work-pieces requiring high corrosion, oxidation, heat and impact resistance.

PROCEDURE

Clean the weld zone of rust, scale and grease. Bigger work pieces are preheated to about 570 F (300 C). Keep the amperage as low as possible, so as to fuse the parent metal as little as possible. Guide the electrode vertically, Keeping the arc short. Weave only slightly. Cool slowly in oven or under asbestos. Still machinable with tungsten carbide tools.

TECHNICAL DATA & WELDING PARAMETERS

Hardness of the weld metal	: 38 - 42 HRC		
Size (diameter)/length (mm)	: 3.15 x 350	4.00 x 350	5.00 x 350
Current (amps)	: 70 - 100	90 - 120	120 - 150
Current	: AC/DC (+)		