

Weartech™ WT-21 TIG

Hardfacing • AWS A5.21 ERCoCr-E

Applications

- ▶ Steam Valves
- ▶ Hot Shears
- ▶ Chemical and Petrochemical Valves
- ▶ Cavation Repair
- ▶ Forging Dies

Welding positions

All

Welding Processes

- ▶ Gas Tungsten Arc Welding
- ▶ Oxyfuel Welding

DIAMETERS / PACKAGING

Diameter in (mm)	10 lb (4.5 kg) Carton
1/8 (3.2)	B1210-320X915
5/32 (4.0)	B1210-400X915

DEPOSIT COMPOSITION

	%C	%Mn	%Si	%Cr	%Ni
Requirements AWS A5.21 ERCoCr-E	0.15-0.40	1.5 max	1.5 max	25-30	1.5 -4.0
Typical Results	0.22	0.9	0.9	27.5	2.9
	%Fe	%Mo	%W	%Co	Hardness, Rc
Requirements AWS A5.21 ERCoCr-E	3.0 max	4.5-7.0	0.50 max	Balance	Not Required
Typical Results	1.5	5.6	0.1	60	27

TYPICAL OPERATING PROCEDURES

Polarity	Current (Amps) 1/8 in (3.2 mm)
DC-	115-135

Diam.	4.54 kg Pack
3.2mm	WT-2132
4.0mm	WT-2140

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