



Changzhou Sanzhong Welding Materials Co.,Ltd

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Standard AWS A5.13 AWS A5.21	Chemical Composition %									
	C	Cr	Mn	Si	W	Ni	Fe	Co	Other	Hardness (HRC)
ERFeCr- A1	1.5 – 3.5	8 – 14	0.5 – 1.5	≤2.0	---	≤2	Bal	---	---	45-52
ERFeCr- A5	3.5 – 6.0	24 – 32	0.5 – 1.5	≤2.0	---	≤4	Bal	---	Mo≤4	58-64
ERFeCr- A6	3.0 – 5.0	22 – 28	1.0 – 2.0	≤2.0	---	small	Bal	---	small Mo	55-60
ERFeMn- A	0.8 – 1.4	≤4	12 – 16	≤1.5	---	---	Bal	---	---	45-55
ERCoCr- A (Stellite 6)	0.7 – 1.4	25 – 32	≤1.0	≤2.0	3-6	≤3	≤4	Bal	---	40-45
ERCoCr- B (Stellite 12)	1.3 – 1.8	28 – 32	≤1.0	≤2.0	7 – 9.5	≤3	≤4	Bal	---	48-53
ERCoCr- C (Stellite 1)	2.0 – 2.8	30 – 34	≤1.0	≤2.0	10 – 14	≤3	≤3	Bal	---	51-56
ERNiCr- C	0.4 – 0.8	28 – 35	≤1.5	≤2.0	---	Bal	≤8	---	---	38-44
ERNiCrFe- A	≤0.35	20 – 28	≤1.5	≤2.0	---	Bal	15 – 25	---	---	30-38
ERWC- A	Matrix C ~0.3 – 0.8	8 – 12	≤1.5	≤2.0	WC particles	≤5	Bal	---	WC particles 40 – 60% by weight	Matrix 40 – 50; WC >70
Type	Spool (MIG)					Tube (TIG)				
Specification (MM)	0.8、 0.9、 1.0、 1.2、 1.6、 2.0					1.6、 2.0、 2.4、 3.2、 4.0、 5.0				
Performance characteristics	AWS A5.21 ERFeCr- A1, ERFeCr- A5, ERFeCr- A6, ERFeMn- A, ERCoCr- A, ERCoCr- B, ERCoCr- C, ERNiCr- C, ERNiCrFe- A and ERWC- A surfacing wires deliver distinct performance characteristics including balanced abrasion & impact, hypereutectic high - Cr abrasive resistance, work- hardening impact resistance, Stellite cobalt hot hardness & cavitation resistance, nickel- base high- temp oxidation / corrosion resistance and WC composite extreme abrasive wear performance for different hardfacing overlay conditions.									



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