



SELECTARC Co6

"Grade 6" Type Cobalt Base Hardfacing Electrode

Classification

AWS A5.13 : ECoCr-A
EN 14700 : E Co2

DIN 8555 : E20-UM-45-CRTZ

Characteristics

Hardfacing electrode with a rutile-basic coating. Cobalt base deposit of « stellite grade 6 » type (Co-Cr-W). The deposit is highly resistant for metal to metal wear and to corrosion up to 800°C. High resistance to Thermal and Mechanical shocks. Good aptitude to polishing and to machining. Soft arc, easy to remove slag, Regular and smooth weld profile.

* Note : "Stellite" is a trade mark of Deloro Stellite (Haynes International)

Applications

Hardfacing of Valves, Valve seats and Sealing surfaces, Hot shear Blades, Hot pressing Tools, Beaters for Coke pulverises.

Typical Weld Metal Composition (%)

C	Si	Cr	W	Fe	Co
1.10	1.00	28.00	4.50	3.00	base

All Weld Metal Mechanical Properties (Typical)

Hardness +20°C (HRC)		Hardness +600°C (HRC)	
AW (Obtained on pure weld metal)		AW	
40 - 45		30	

Welding Current & Instructions

Electrode	∅ x L (mm)	2.5 x 300	3.2 x 350	4.0 x 450	5.0 x 450
Current	(Amp)	65 - 75	90 - 100	130 - 140	160 - 180

Redrying of electrode at 250°C for 1hr before use, if necessary. Preheat massive pieces 250-400°C. Keep the dilution with the parent metal low and cool down slowly to reduce the risk of cracking while cooling. Weld eventual cushion layer with Selectarc 18/8 Mn.



1G/PA



2F/PB



2G/PC

= + ~ 70 V

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