


Technical data sheet <small>011121MBA</small>	Cored welding wire STELLOY 6-TIG	 Welding Alloys
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CLASSIFICATION

EN 14700: T Co2
ASME IIC SFA 5.21 / AWS A 5.21: ERCCoCr-A

DESCRIPTION

- Cobalt base tubular wire for gas tungsten arc welding
- Produces weld beads with a minimum of slag related islands
- Also applicable to the MIG process
- Exceptional resistance to metal-to-metal wear in corrosive media at high temperatures, to erosion and to thermal shocks

APPLICATIONS

STELLOY 6-TIG is used for hardfacing parts undergoing the single or combined effects of metal-to-metal wear, abrasion, temperatures ranging from RT to 800°C, impacts and corrosive environments.

Examples

Used extensively on valve seats of diesel engines, cams, chainsaw bars, hot shear blades, cold forming rolls and hot forming rolls, for hot rolling reinforcing bar, pump parts and components in hot zinc baths.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	W	Fe	Co
1.0	0.9	1.4	29	5	4	Bal.

Structure: chromium and tungsten carbides in an austenitic type matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

Three-layer deposit on mild steel: 42 HRc

High temperature hardness:

20°C	200°C	400°C	600°C	800°C
420 HB	360 HB	330 HB	240 HB	140 HB

High deposition rates and low dilution are facilitated by pulsed current

High heat inputs favour lower hardness

PACKAGING

Diameter	1.2 – 1.6 mm
Standard packaging	EN ISO 544: BS 300 spools
Weight	15 kg

Other packaging and other diameters: please consult us