

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

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
- STELLOY 6BC-TIG is equivalent to STELLOY 6-G with a lower carbon.
- Easier to machine and less sensitive to cracking when compared to STELLOY 6-G.
- Used in automatic and semi-automatic welding where STELLOY 6-G would give cracking problems
- Exceptional resistance to metal-to-metal wear in corrosive media at high temperatures, to erosion and to thermal

APPLICATIONS

STELLOY 6BC-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, impact and corrosive environments.

Examples

Valve seats, valve gates, valve wedges, valve and cylinder bodies etc.

TYPICAL ALL-WELD METAL ANALYSIS

C	Mn	Si	Cr	W	Fe	Co
0.90	1.00	1.00	29.0	5.00	3.60	Bal.

Structure: chromium and tungsten carbides in an austenitic type matrix

TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness:

Three-layer deposit on mild steel: 38 HRc

- High deposition rates and low dilution are facilitated by pulsed current
- High heat inputs favour lower hardness

STANDARD DIAMETERS (mm)

1.2, 1.6 mm

Other diameters: please consult us

PACKAGING

Diameter	1.2 – 1.6 mm
Standard packaging	EN ISO 544: BS300 spools
Weight	15 kg

Other packaging: please consult us