



## FCW CO6

### Classification

AWS A5.21 : ERCCoCr-A

EN 14700 : T Co2

### Description & Applications

Cobalt base tubular metal-cored wire for gas shielded (Ar 100%) hardfacing type Cobalt Grade 6. Exceptional resistance to wear combined or not to abrasion, metal-metal wear, corrosion up to 1000°C. Nonmagnetic weld deposit

**Main applications:** Hot shear blades, valve seats and litters, forging tools.

### Typical Chemical Composition ( % )

	C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S	Co
Min	0.7		0.1	25				4.0			
Max	1.4	2.0	2.0	32	3.0	1.0	5.0	6.0	0.03	0.03	Rem.
Type	1.05	1.1	1.0	28.5	0.15	0.04	3.7	4.7	0.005	0.01	Rem.

Σ Others elements : <1.0

### All Weld Metal Mechanical Properties

Hardness (3<sup>rd</sup> layer)

~ 42 HRC as welded

### Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters			Shielding Gas
		Current (A)	Voltage (V)	Stick out (mm)	
FCAW = + / pulsed	1.2	100 - 250	16 - 29	15 - 30	ISO 14175 : I1 (Ar) 10 - 20 l/min
	1.6	140 - 350	16 - 30	15 - 30	



FT En-CC02-210415

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