



FCW CO6L

Cobalt grade 6 flux cored wire

Classification

AWS A5.21 : ERCCoCr-A

EN 14700 : T Co2

Description & Applications

Low carbon Cobalt base tubular 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 800°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				3.0			
Max	1.4	2.0	2.0	32	3.0	1.0	5.0	6.0	0.03	0.03	Rem.
Type	0.9	1.0	1.0	29.0	0.15	0.05	3.6	5.0	0.01	0.01	Rem.

Σ Others elements : <1.0

All Weld Metal Mechanical Properties

Hardness (3rd layer)

~ 38 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) M13 (Ar + O ₂) 10 - 20 l/min
	1.6	140 - 350	16 - 30	15 - 30	



FT En-CC06-210429

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