MIG CO6

Classification

AWS A5.21 : ERCoCr-A
DIN 8555 : MSG-20-GZ-40-CTZ
EN 14700 : S Co2

Description & Applications

Cobalt base solid wire for MIG harfacing of Stellite™ Grade 6*. Highly resistant to metal-metal wear and to corrosion up to 800°C. High resistance to thermal and mechanical shocks. Good aptitude to polishing and to machining.

Main applications: Hardfacing of valves, valve seats and sealing surfaces, hot shear blades, hot pressing tools, beaters for coke pulverises.

* Trademark Kennametal

Typical Chemical Composition (%)

	C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S	O/T	Co
Min	0.9		0.1	26				4				
Max	1.4	2.0	1.0	32	3.0	1.0	3.0	6.0	0.03	0.03	0.50	Rem.
Type	1.2	1.2	0.20	29.5	2.5	0.30	2.4	4.6	0.02	0.01	<0.50	Rem.

All Weld Metal Mechanical Properties

	Hardness (HRC)		
Temperature (°C)	+20°C	400°C	600°C
Type	39-43	~34	<20

Welding Current & Instructions

Welding mode	Wire Ø (mm)	Welding parameters		Shielding Gas
		Current (A)	(V)	
MIG = +	1.2 1.6	140-180 160-200	22-27 24-28	ISO 14175: I1(Ar) / M11 (Ar/CO_2) 18 L/min

Preheat massive parts or special steels to 300-600°C. Keep this temperature during welding and cool down slowly, preferable in an oven, to reduce the risk of cracking while cooling.

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