TIG CO6

Classification

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

Description & Applications

Cobalt base solid rod for TIG or oxyfuel 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	A/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	Shielding Gas
TIG = -	ISO 14175 : I1 (Ar) 6-12 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.

For oxyfuel hardfacing, use a reducing flame (slight excess of acetylene).