



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 hardfacing 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

Temperature (°C)	Hardness (HRC)		
	+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).

FT En-TB02-170711

Liability: This document is intended to assist the user in choosing the product. It is up to the user to verify that the chosen product is suitable for applications for which it is intended. The company FSH Welding Group reserves the right to alter specifications without prior notice of its products. The descriptions, illustrations and specifications are for reference only and cannot be held liable for FSH Welding Group. **Fumes:** Consult information on MSDS, available upon request.

www.fsh-welding.com - info@fsh-welding.fr