



Selectarc Co6

*“Grade 6” type cobalt base
Hardfacing Electrode*

Description & Applications

Hardfacing electrode with a rutile-basic coating. Cobalt base deposit of « stellite grade 6 » type (Co-Cr-W). The deposit is 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. Soft arc, easy to remove slag, regular and smooth weld profile.

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

* Note : "Stellite" is a trade mark of Deloro Stellite (Haynes International).

All Weld Metal Mechanical Properties

Hardness (as welded) +20°C
40-45 HRC

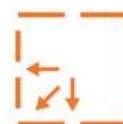
Hardness (as welded) +600°C
~30 HRC

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350	5,0x450
Current	(A)	75	100	140	180

Redrying 1h at 250°C, if necessary. Preheat massive pieces 250-400°C. Keep the dilution with the parent metal low and cool down slowly to reduce the risk of cracking while cooling. Weld eventual cushion layer with Selectarc 18/8 Mn.

ind.13



= + ~ 70V

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