



FCW CO6

Cobalt grade 6 flux cored wire

Classification

AWS A5.21 : ERCCoCr-A EN 14700 : TCo2
 DIN 8555 : MSG 20-GF-40-CTZ

Description & Applications

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 1000°C. Nonmagnetic weld deposit

Main applications: Hot shear blades, valve seats and litters.

Typical Chemical Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe	W	P	S	Co
1.05	1.0	1.0	29.0	0.15	0.05	4.00	4.6	0.01	0.01	Rem.

All Weld Metal Mechanical Properties

Hardness (3rd layer)
 ~ 42 HRC

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) 10 - 20 l/min
	1.6	140 - 350	16 - 30	15 - 30	



FT En-CC02-160211

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