

Classifications

AWS A5.13 / SFA-5.13	EN 14700	DIN 8555
ECoCr-A	E Z Co2	E 20-UM-40-CSTZ

Characteristics and typical fields of application

WEARstick Co 6 is used for hardfacing on parts subject to a combination of erosion, corrosion, cavitation, impact, pressure, abrasion and high temperatures up to 900 °C, such as tight surfaces on fittings, valve seats and cones for combustion engines, gliding surfaces metal-metal, highly stressed hot working tools without thermal shock, milling mixers and drilling tools.

Excellent gliding characteristics, easy polishability, good toughness, nonmagnetic. Machining by grinding or with tungsten carbide cutting tools.

WEARstick Co 6 has excellent welding properties and a homogenous, finely rippled seam due to spray arc. Very easy slag removal.

Hardness of the pure weld deposit: 40 – 42 HRC


Hardness at 500 °C: approx. 30 HRC

Hardness at 700 °C: approx. 160 HB

Typical analysis

	C	Cr	W	Co
wt.-%	1.1	27.5	4.5	bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	2 h / 300°C	2.5 × 300	40 - 60
			3.2 × 350	70 - 110
			4.0 × 350	90 - 130
			5.0 × 350 *	110 - 150

* available on request

Welding instructions

Clean welding area, preheating temperature 450 – 600 °C, very slow cooling. Hold stick electrode vertically and with a short arc and lowest possible amperage. Redry stick electrodes that have become damp for 2 h / 300 °C.

Approvals

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