




CEWELD AA DUR 6

TYPE	Cobalt based (Stellite 6) fluxcored welding wire (FCAW) for overlay welding.								
APPLICATIONS	Cladding valves, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, seats, cutting knives, metal to metal wear, bearing surfaces, chemical industry, hot shear blades etc. Cladding valves, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, seats, cutting knives, metal to metal wear, bearing surfaces, chemical industry, hot shear blades etc.								
PROPERTIES	Outstanding alloy against abrasion, thermo-shock and corrosion combined with high temperatures. The weld deposit can be machined with tungsten tool tips and by grinding. The hardness of the weld deposit will decrease 16% at 300°C and about 30% at 600°C. Excellent alloy against thermal shock, abrasion, erosion, corrosion and cavitation at high temperature.								
CLASSIFICATION	AWS	A 5.21: ERCoCr-A							
	EN ISO	14700: T Co2							
	DIN	8555: MSG 20-GF-40-CTZ							
	F-nr	71							
SUITABLE FOR	ER CoCr-A Stellite 6 Celist 706								
APPROVALS	No Approvals Found								
WELDING POSITIONS									
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	C	Si	Mn	Cr	Ni	Mo	Fe	W	Co
	1	1	0.8	28	2	0.01	3	4.5	Rem.
ALL WELD MECHANICAL PROPERTIES	Heat Treatment	R _{p0,2} MPa	R _m MPa	A5 (%)	Hardness Rockwell C				
	As Welded /				Avg. 43				
REDRYING TEMPERATURE	140°C / 24 hr								
GAS ACCORDING EN 14175	M13								



CEWELD AA DUR 6

AA DUR 6 0,8MM

Type	KG/unit	EANCode
BS-300	15	8720663402011

AA DUR 6 1,2MM

Type	KG/unit	EANCode
BS-300	15	8720663402028

AA DUR 6 1,6MM

Type	KG/unit	EANCode
BS-300	15	8720663402042