



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.

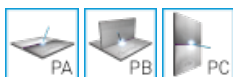
CLASSIFICATION

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

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.

MECHANICAL PROPERTIES

Heat Treatment	R _{P0,2} (MPa)	R _m (MPa)	A ₅ (%)	Hardness
As Welded				43 HRc

REDRYING 140°C / 24 hr

GAS ACC. EN ISO 14175 M13



CEWELD AA DUR 6

AA DUR 6 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402011

AA DUR 6 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402028

AA DUR 6 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402042