

Colmonoy 6

CATEGORY GMAW-GTAW Solid wires

TYPE Nickel based Tig filler metal for hardfacing and overlay applications.

APPLICATIONS Colmonoy® 6 offers outstanding metallurgical and physical properties making them ideally suited to solving wear mechanisms such as abrasion, erosion, corrosion and high-temperatures encountered in service.

PROPERTIES This nickel based alloy offers superior wear protection, retaining its hardness up to 600°C (1000°F) with significant resistance to oxidation.

CLASSIFICATION

AWS	A 5.14:
	AMS:
EN ISO	18274:

SUITABLE FOR Aircraft gas turbines, steam turbine powerplants, turbochargers and valves in reciprocating engines, prosthetic devices, heat treating equipment, pollution control equipment, coal gasification and liquefaction systems, and components in pulp and paper mills.

APPROVALS CE approved

WELDING POSITIONS:



ALL WELD METAL ANALYSIS % (TYPICAL)

C	Ni	Cr	B	Si	Fe
0.7	Bal	14	3.0	4.25	4.0

NOMINAL MECHANICAL PROPERTIES (AS WELDED)

Working temperature	Rp0,2 (N/mm ²)	Rm (N/mm ²)	A5 (%)	Impact Energy (J) ISO-V			Hardness HRc
				20°C	-40°C	-60°C	
							56-61

AW: as welded

WELDING PARAMETERS / PACKING

D (mm)	Welding Parameters		Voltage (V)	Packing (kg)	
	Current (A) DC-			single	master
2,4	100-200		11-14	5	25
3,2	120-250		11-14	5	25
4,0	150-280		10-12	5	25
5,0	180-300		9-11	5	25

REDRYING TEMPERATURE not required

GAS ACC EN ISO 14175: I1