

DUR 6 TIG

CATEGORY GMAW-GTAW Solid wires

TYPE Cobalt-based thermo shock resistant alloy for overlay applications.

APPLICATIONS Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves.

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. The weld deposit is high heat resistant up to 900°C. Dur 6 offers a low coefficient of friction of 0.12 and exceptional resistance to galling. It has cavitation-erosion resistance ten times that of 304 stainless steel, Dur 6 can be used to protect bearing surfaces in non-lubricating conditions due to its resistance to metal-to-metal wear.

CLASSIFICATION

AWS	A 5.21: ER CoCr-A
EN ISO	14700: RZ Co2
DIN	8555: WSG 20-G0-40-CTZ

SUITABLE FOR Stellite 6 alloy for, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves and seats

APPROVALS CE approved

WELDING POSITIONS:

WELD METAL ANALYSIS %

Co	C	Si	Cr	W	Mn	Fe
Bal.	1.1	1.0	28	4.5	0.6	

WELDING PARAMETERS PACKING

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / master	kg / 1000
2.4	1000		5	25	1000
3.2	1000		5	25	1000
4.0	1000		5	25	1000
5.0	1000		5	25	1000

REDRYING TEMPERATURE not required

NOTE Also available as fluxcored wire for Mag welding