

## Dur 6U

**CATEGORY** SMAW Stick Electrodes

**TYPE** Cobalt-based welding electrode for overlay applications.

**APPLICATIONS** 43-45 HRC, stellite 6 alloy with outstanding properties against abrasion, thermo-shock and corrosion combined with high temperatures.

**PROPERTIES** Excelent welding properties and self detaching slag. The weld deposit can be machined with tungsten tool tips and by grinding. The hardness of the weld deposit will degeas 16% at 300°C and about 30% at 600°C. The weld deposit is high heat resistant up to 900°C.

**CLASSIFICATION**

AWS	A 5.13: E CoCr-A
EN ISO	14700: EZ Co2
DIN	8555: E20-UM-40-CTZ

**SUITABLE FOR** Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, pumps, plastic recycling etc.

**APPROVALS** CE approved

**WELDING POSITIONS:**



**WELD METAL ANALYSIS %**

C	Mn	Co	Cr	W	Fe
1.1	0.6	basis	28.0	4.5	<2.5

**MECHANICAL PROPERTIES**

Heat Treatment	R <sub>p0,2</sub> (N/mm <sup>2</sup> )	R <sub>m</sub> (N/mm <sup>2</sup> )	A <sub>5</sub> (%)	Impact Energy (J) ISO-V		
				20°C	300°C	600°C
AW				40-43	33-36	28-31

AW: as welded

**WELDING PARAMETERS / PACKING**

D (mm)	Welding Parameters		Packing		
	Length (mm)	Current (A)	kg / can	kg / 6pack	kg / 1000
2.5	350	70-90	2.8	16.8	23.4
3.2	350	90-130	2.8	16.8	37.9
4.0	350	120-160	2.8	16.8	54.9
5.0	350	140-180	2.8	16.8	86.2

**EQUIVALENT** FCAW - DUR 6