



COBALTHERME-6

CODIFICATION: AWS : SFA 5.13 ECoCr-A

CHARACTERISTICS AND APPLICATIONS:

Cobaltherme-6 is a cobalt based electrode depositing a weld metal having 28Cr - 5W - 1C. The weld metal possesses excellent resistance to oxidation, impact, corrosion and heat. The electrode operates well in AC as well as DC.

There are several applications in which this electrode can be used. This includes overlay, surfacing applications, which requires heat resistance, oxidation resistance in combination with impact and mild abrasion. Typical applications include, shear blades, dies, valve seats, hot metal handling equipments.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr	Ni	Mo	W	Co	Fe
Percent	: 1.0	1.8	0.94	28.0	2.80	1.0	5.0	Bal.	4.5

HARDNESS OF ALL WELD METAL (As Welded, After 3 Layers on Mild Steel): 40-45 HRC

CURRENT AND PACKING DATA: AC/DC(+)

Size (mm)	:	5x350	4x350	3.15x350
Dia x Length				
Current Range (Amps)	:	130-190	100-150	70-120
Quantity	:	1	1	1
(Kgs./Carton)				

PRECAUTIONS:

1. Ensure the electrodes are dry. Redry the electrodes at 200°C for one hour before use.
2. Follow a carefully designed welding procedure, which will use preheating only wherever necessary.
3. The post-weld heat treatment is not normally recommended.
4. General precautions like removal of contaminants, dirt to be followed.