# STELLOY 6-E

## CLASSIFICATION

AWS A5.13 : ECoCr-A

EN 14700 : E Co2

## DESCRIPTION AND APPLICATIONS

• Rutile basic coated electrode

• Combines all the outstanding properties of the cobalt base alloys, including abrasion and erosion resistance

• Deposit of intermediate hardness with good machinability

• Wide field of applications: hot shearing tools, petrochemical and industrial valves, valves and valve seats of marine engines, pump sleeves and shafts

• Complements Welding Alloys cored wire STELLOY 6

## TYPICAL ALL-WELD METAL ANALYSIS

| C | Si | Cr | W | Fe | Co |
|---|---|---|---|---|---|
| 1.10 | 1.00 | 28.0 | 4.50 | 3.00 | Balance |

## TYPICAL ALL-WELD METAL MECHANICAL PROPERTIES

Hardness as welded

44 HRc

## OPERATING CONDITIONS

| | | | |
|---|---|---|---|
| **Electrode ØxL [mm]** | 2.5x300 | 3.2x350 | 4.0x350 |
| **Current [A]** | 75 | 100 | 140 |

Redrying of the electrodes: 250°C/1h if necessary. Preheat massive pieces 250-400°C. Keep the dilution with the parent metal low and cool down slowly to reduce the risk of cracking while cooling.

**= + ~ 70 V**

## WELDING POSITIONS

1G/PA, 2F/PB, 2G/PC

## PACKAGING

| | | | |
|---|---|---|---|
| **Electrode ØxL [mm]** | 2.5x300 | 3.2x350 | 4.0x350 |
| **Weight/box [kg]** | 4 | 5 | 5 |