



CEWELD AA DUR 6

TYPE	Cobalt based (Stellite 6) fluxcored welding wire (FCAW) for overlay welding.																									
APPLICATIONS	Cladding valves, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, seats, cutting knives, metal to metal wear, bearing surfaces, chemical industry, hot shear blades etc. Cladding valves, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, seats, cutting knives, metal to metal wear, bearing surfaces, chemical industry, hot shear blades etc.																									
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. Excellent alloy against thermal shock, abrasion, erosion, corrosion and cavitation at high temperature.																									
CLASSIFICATION	AWS EN ISO DIN F-nr	A 5.21: ERCCoCr-A 14700: T Co2 8555: MSG 20-GF-40-CTZ 71																								
SUITABLE FOR	ER CoCr-A Stellite 6																									
APPROVALS																										
WELDING POSITIONS																										
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table border="1" style="width: 100%; border-collapse: collapse; text-align: center;"> <thead> <tr> <th>C</th> <th>Si</th> <th>Mn</th> <th>Cr</th> <th>Ni</th> <th>Mo</th> <th>Fe</th> <th>W</th> <th>Co</th> </tr> </thead> <tbody> <tr> <td>1</td> <td>1</td> <td>0.8</td> <td>28</td> <td>2</td> <td>0.01</td> <td>3</td> <td>4.5</td> <td>Rem.</td> </tr> </tbody> </table>								C	Si	Mn	Cr	Ni	Mo	Fe	W	Co	1	1	0.8	28	2	0.01	3	4.5	Rem.
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As Welded				43 HRc																						
REDRYING	140°C / 24 hr																									
GAS ACC. EN ISO 14175	M13																									



CEWELD AA DUR 6

AA DUR 6 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402011

AA DUR 6 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402028

AA DUR 6 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402042