SK STELKAY 6A-G

gas shielded metal cored wire

Classifications	
DIN 8555	ASME IIC SFA 5.21
MF 20-GF-45-CTZ	ERC CoCr-A

Characteristics

Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode.

Microstructure:	Cr and W carbides in an austenitic matrix
Machinability:	Good with metallic carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	Argon 98% + Oxygen 2% or Argon 100%

Field of use

Valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches.

Typical analysis in %

C	Mn	Si	Cr	Co	W	Fe
1,35	0,8	1,5	27,0	balance	3,5	3,0

Typical mechanical properties

Hardness as welded: 43 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,2	110-180	20-31	20 max.	12-15
1,6	150-250	20-31	20 max.	15-18

All information provided is based upon careful investigation and intensive research.
However, we do not assume any liability for correctness and information is subject to change without notice.