SK STELKAY 6 T-G

gas shielded metal cored wire

Classifications	
DIN 8555	AWS A5.21
MF 20-GF-40-CTZ	ERC CoCr-A

Characteristics

Cobalt base wire designed to be used with the GTAW process (TIG). Alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature.

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 100%
Metal cored	

Field of use

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

Typical coating analysis in %

C	Mn	Si	Cr	Co	W	Fe
0.96	0.8	1.5	29.5	BAL	4.7	3.1

Typical mechanical properties

Hardness as welded: 40 HRC

Recommended spraying parameters

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

All informations 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.