DESCRIPTION

Stoodite® 6-M is the tubular wire version of a cobalt alloy that produces a medium hardness cobalt-chromium deposit for high temperature applications with good abrasive wear and good impact resistance. It is the most versatile and widely used cobalt alloy. Chromium carbides contained in the deposit provide excellent resistance to many forms of chemical and mechanical degradation, including galling and cavitation erosion. It bonds well with all weldable steels, including stainless.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Excellent
Impact Resistance	Good
Corrosion Resistance	Good
Hardness (2 layers)	HRC 38 - 40
Hot Hardness	Excellent
Magnetic	No
Deposit Layers	2 Maximum
Surface Cross Check	No*
Machinability	Use carbide tools
Specifications	
AWS A5.21-2001	ERCCoCr-A

* With proper preheat and slow cooling.

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	1.2
Chromium	28.1
Iron	4.0
Manganese	0.9
Molybdenum	0.1
Nickel	0.2
Silicon	0.6
Tungsten	4.0
Cobalt	Balance

TYPICAL APPLICATIONS

Typical applications include:
- Flights of extrusion screws
- Sinker roll bushings in steel mill
- Soaking pit tong bits
- Shafts

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	.045 (1.2)	1/16 (1.6)
Current, Amp. DCEP	180 - 200	280 - 300
Voltage	25 - 27	26 - 28
Shielding Gas	Argon	Argon
Wire Extension	1/2" - 5/8"	5/8" - 3/4"
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	25# Spool	810722182045
1/16" (1.6mm)	25# Spool	810722182062

Stoody Company