

Bare Wire Cobalt

Alloy: WWCobalt #6 Bare Wire / Rod

Conforms to Certification: AWS A5.21 ASME SFA A5.21

Class: ERCoCr-A

Alloy: ERCoCr-A

Weld Process: GTAW (tig)

AWS Chemical Composition Requirements

| | |
|---------------|------------------|
| C = 0.9 - 1.4 | Mo = 1.0 max |
| Mn = 1.0 max | Fe = 3.0 max |
| Si = 2.0 max | W = 3.0 - 6.0 |
| Cr = 26 - 32 | Co = Remainder |
| Ni = 3.0 max | Other = 0.50 max |

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Deposited Chemical Composition % (Typical)

| | |
|-----------|--------------|
| C = 1.3 | Mo = 0.1 |
| Mn = 0.09 | Fe = 1.0 |
| Si = 1.3 | W = 5.5 |
| Cr = 30.6 | Co = Balance |
| Ni = 1.0 | |

Recommended Operation of Welding Rods

Flat Welding

| <u>Diameter</u> | <u>Amps DCEN</u> | <u>Volts</u> | <u>Shielding Gas</u> |
|-----------------|------------------|--------------|----------------------|
| 1/8 | 90 – 120 | 20 – 24 | argon |
| 5/32 | 120 – 140 | 20 – 24 | argon |

Description

Cobalt #6 Bare Wire (ERCoCr-A) provides resistance to many forms of chemical and mechanical degradation over a wide temperature range. It bonds well with all weldable grade steels, including stainless.

Deposited All Weld Metal Properties % (AW)

| | | |
|--------------------|-----|---------|
| Hardness (2 layer) | HRC | 40 – 42 |
|--------------------|-----|---------|

