

Bare, Coated & Flux-cored Cobalt

Alloy: WWCobalt #6 Coated Electrode

Conforms to Certification: AWS A5.13 ASME SFA A5.13

Class: ECoCr-A

Alloy: ECoCr-A

Weld Process: Shielded Metal Arc

AWS Chemical Composition Requirements

C = 0.7 - 1.4	Mo = 1.0 max
Mn = 2.0 max	Fe = 5.0 max
Si = 2.0 max	W = 3.0 - 6.0
Cr = 25 - 32	Co = Remainder
Ni = 3.0 max	Other = 1.0 max

Deposited Charpy-V-Notch Impact Properties %

Not Applicable

Recommended Operation of Welding Rods

Flat Welding

<u>Diameter</u>	<u>Amps DCEP</u>
1/8	90 - 120
5/32	135 - 170

Deposited Chemical Composition % (Typical)

C = 1.1	Mo = 0.1
Mn = 0.1	Fe = 3.2
Si = 1.0	W = 4.5
Cr = 25.8	Co = Balance
Ni = 1.9	

Application

Cobalt #6 Coated Electrodes (ECoCr-A) produce a medium hardness cobalt-chromium deposit for high temperature applications with good abrasive wear and good impact resistance. Type 6 is the most versatile and widely used cobalt alloy with a good balance of abrasion and impact resistance. Chromium carbides contained in the deposit have excellent resistance to many forms of chemical and mechanical degradation, including galling and cavitation erosion. It bonds well with all weldable steels, including stainless.

Deposited All Weld Metal Properties % (AW)

Hardness (2 layer)	HRC	38 - 40
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