



# CEWELD AA DUR 6

TYPE	Cobalt based (Stellite 6) fluxcored welding wire (FCAW) for overlay welding.																										
APPLICATIONS	Cladding valves, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, seats, cutting knives, metal to metal wear, bearing surfaces, chemical industry, hot shear blades etc. Cladding valves, Steam-valves, high temperature liquid pumps, hot cutting tools, exhaust valves, seats, cutting knives, metal to metal wear, bearing surfaces, chemical industry, hot shear blades etc.																										
PROPERTIES	Outstanding alloy against abrasion, thermo-shock and corrosion combined with high temperatures. The weld deposit can be machined with tungsten tool tips and by grinding. The hardness of the weld deposit will decrease 16% at 300°C and about 30% at 600°C. Excellent alloy against thermal shock, abrasion, erosion, corrosion and cavitation at high temperature.																										
CLASSIFICATION	<table><tr><td>AWS</td><td>A 5.21: ERCCoCr-A</td></tr><tr><td>EN ISO</td><td>14700: T Co2</td></tr><tr><td>DIN</td><td>8555: MSG 20-GF-40-CTZ</td></tr><tr><td>F-nr</td><td>71</td></tr></table>									AWS	A 5.21: ERCCoCr-A	EN ISO	14700: T Co2	DIN	8555: MSG 20-GF-40-CTZ	F-nr	71										
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SUITABLE FOR	ER CoCr-A Stellite 6																										
APPROVALS																											
WELDING POSITIONS																											
TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)	<table><tr><td>C</td><td>Si</td><td>Mn</td><td>Cr</td><td>Ni</td><td>Mo</td><td>Fe</td><td>W</td><td>Co</td></tr><tr><td>1</td><td>1</td><td>0.8</td><td>28</td><td>2</td><td>0.01</td><td>3</td><td>4.5</td><td>Rem.</td></tr></table>									C	Si	Mn	Cr	Ni	Mo	Fe	W	Co	1	1	0.8	28	2	0.01	3	4.5	Rem.
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MECHANICAL PROPERTIES	<table><thead><tr><th>Heat Treatment</th><th><math>R_{P0.2}</math> (MPa)</th><th><math>R_m</math> (MPa)</th><th>A5 (%)</th><th>Hardness</th></tr></thead><tbody><tr><td>As Welded</td><td></td><td></td><td></td><td>43 HRc</td></tr></tbody></table>									Heat Treatment	$R_{P0.2}$ (MPa)	$R_m$ (MPa)	A5 (%)	Hardness	As Welded				43 HRc								
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As Welded				43 HRc																							
REDRYING	140°C / 24 hr																										
GAS ACC. EN ISO 14175	M13																										



# CEWELD AA DUR 6

AA DUR 6 0,8MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402011

AA DUR 6 1,2MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402028

AA DUR 6 1,6MM

Packaging	KG/unit	EanCode
BS-300	15	8720663402042