

# Meltolit

## Co6 MCW

AWS A 5.21: ERCCoCr-A

EN 14700 TCo2

### DESCRIPTION

Cobalt base tubular wire for gas shielded metal arc hardfacing. Exceptional resistance to metal-to-metal wear in corrosive media at high temperatures, to erosion and to thermal shocks. Structure: chromium and tungsten carbides in an austenitic type matrix.

Machinable by hard faced tools.

Applications: Steam and chemical valves, cams, chainsaw bars, hot shear blades, cold forming rolls and hot forming rolls, pump parts etc

#### WELDING POSITIONS



#### CURRENT TYPE

DC(+) /pulsed

#### GAS

EN ISO 14175: I1(Ar)

### MECHANICAL PROPERTIES

#### Hardness

As welded 42 HRC

400°C 33 HRC, 600° 24 HRC

### TYPICAL CHEMICAL COMPOSITION(%)

C	Si	Mn	Cr	W	Fe	Co	
1,05	1,0	1,0	29,0	4,5	4,0	Rest	

### PACKING INFORMATION AND WELDING PARAMETERS

Dimension(mm)	1,2	1,6
Spool(kg)	15	15
Stick-out(mm)	15-30 (optimum 25)	15-30 (optimum 25)
Amperage(A)	100-250 (optimum 200)	140-350 (optimum 250)
Voltage(V)	16-29 (optimum 28)	16-30 (optimum 28)
Gas flow(l/min)	10-20	10-20

### EQUIVALENT CONSUMABLES

MMA	Meltolit Co6 E
TIG	Meltolit Co6 Tig