

## Classifications

|                   |          |            |
|-------------------|----------|------------|
| DIN 8555          | EN 14700 | AWS A 5.21 |
| WSG 20-GO-40-CSTZ | R Z Co2  | ER CoCr-A  |

## Characteristics and field of use

WEARtig Co 6 is suitable for hardfacing of parts subject to a combination of erosion, corrosion, cavitation, pressure, impact, abrasion and high heat up to 900°C, such as tight surfaces of fittings, valve seats and cones for combustion engines, gliding surfaces metal to metal, highly stressed hot working tools without thermal shock, milling, mixing and drilling tools.

Excellent gliding characteristics, very good polishability, high toughness, non-magnetic. Machinable by grinding and with tungsten carbide tools.

Hardness of pure weld deposit: 40 – 42 HRC  
 Hardness at 500°C: approx. 33 HRC

## Rod analysis in %

| C   | Cr   | W   | Co      |
|-----|------|-----|---------|
| 1.2 | 27.0 | 4.5 | balance |

## Welding instruction

Clean welding area, preheating temperature 450-600°C, very slow cooling.

## Welding procedure and availability

| Ø x length    | Current type | Shielding gas (EN ISO 14175) |
|---------------|--------------|------------------------------|
| 2.4 x 1000 mm | DC (-)       | I 1                          |
| 3.2 x 1000 mm | DC (-)       | I 1                          |
| 4.0 x 1000 mm | DC (-)       | I 1                          |

Adjust acetylene excess (reducing flame) in oxyacetylene welding.