SK STELKAY 6 L-G

gas shielded metal cored wire

Classifications

DIN 8555

MF 20-GF-300-CTZ

Characteristics

Cobalt base alloy providing excellent resistance to metal-to-metal wear, oxidation, thermal cycling and impact in corrosive environments at high temperature. For reduced levels of dilution and an improved weldability, we recommend using a pulsed MIG welding mode.

Microstructure:	Cr and W carbides in an austenitic matrix
Machinability:	Good with metallic carbide tipped tools
Oxy-acetylene cutting:	Cannot be flame cut
Deposit thickness:	Depends upon application and procedure used
Shielding gas:	Argon 98% + Oxygen 2% or Argon 100%

Field of use

Valves, valve seats in motor vehicles, hot shear blades, extruder screws, clack valves and seats, dies, punches.

Typical analysis in %

C	Mn	Si	Cr	Co	W	Fe
0,8	0,8	1,0	28,0	balance	4,2	3,0

Typical mechanical properties

Hardness as welded: 35 HRC

Recommended welding parameters

Wire diameter [mm]	Amperage [A]	Voltage [V]	Stick-Out [mm]	Gas-Rate [L/min]
1,6	150-250	20-31	20 max.	15-18