

DESCRIPTION

Stoodite® 6 coated electrodes produce a medium hardness cobalt-chromium deposit for high temperature applications with good abrasive wear and good impact resistance. Stoodite® 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.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Very good
Impact Resistance	Good
Corrosion Resistance	Good
Hardness (2 layer)	HRC 38 - 40
Hot Hardness	Excellent
Magnetic	No
Deposit Layers	2 Maximum
Surface Cross Check	No
Machinability	Use carbide tools
Specifications	
AWS / SFA A5.13-2000	ECoCr-A

TYPICAL DEPOSIT CHEMISTRY (wt%)

Carbon	1.1
Chromium	28.8
Iron	3.2
Manganese	0.1
Molybdenum	0.1
Nickel	1.9
Silicon	1.0
Tungsten	4.5
Cobalt	Balance

TYPICAL APPLICATIONS

Typical applications include:

- Chemical and steam valve trim
- Bearing and bushing areas
- Food processing equipment
- Zinc tanks
- Forging dies
- Trunnions
- Trimmer dies
- Guide rolls
- Diesel engine valves

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, in. (mm)	1/8 (3.2)	5/32(4.0)
Current, Amp. DCEP	90 - 120	135 - 160
Position	Flat	Flat
Diameter, in. (mm)	3/16 (4.8)	1/4 (6.4)
Current, Amp. DCEP	160 - 180	220 - 270
Position	Flat	Flat

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
1/8" (3.2mm)	10# Vac Pak	10242700
5/32" (4.0mm)	10# Vac Pak	10243100
3/16" (4.8mm)	10# Vac Pak	10243500
1/4" (6.4mm)	10# Vac Pak	10243900

Stoody Company

5557 Nashville Road • Bowling Green, KY 42101
1-800-426-1888

PDS-CO-E-002
Revision 3
April 23, 2008

NOTICE - Failure to follow manufacturer's directions for use may result in equipment or material failure and void any applicable warranty. The data provided or referenced herein is provided for informational purposes only, without guarantee or warranty and represents "typical" results when Stoody products are used in accordance with internal Stoody procedures. Other tests and procedures may produce differing results. Stoody expressly disclaims any liability resulting from reliance on this data.
PROTECT YOURSELF AND OTHERS - Users should read and follow all recommended guidance on health and safety from their employer, the supplier, the manufacturer, and government authorities. These, at a minimum including the Warning Labels on the products and the Material Safety Data Sheets ("MSDS"). The MSDS and additional safety information may be found on materials or links at: www.stoody.com.