

**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 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

**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

**OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS**

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

**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

**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**

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