

GEMET ST6

IDENTIFICATION

Gemet ST6, ECoCr-A

CLASSIFICATION

AWS/SFA 5.13: ECoCr -A

DESCRIPTION

Rutile -coated welding electrode on cobalt base, core wire alloyed. Gemet ST6 has excellent welding properties and a homogeneous, finely rippled seam weld metal.

WELD METAL ANALYSIS (RANGE) %

C	Cr	W	Co
1.1 max	27.5 max	4.5 max	balance

MECHANICAL PROPERTIES (RANGE)

Hardness of Pure Weld Metal	Hardness at 600°C
37 - 42 HRC	Approx. 33 HRC

TYPICAL APPLICATIONS

GEMET ST6 is used for high - grade hard -facing on parts subjected to a combination of erosion, corrosion, cavitations, impact, pressure, abrasion and high temperatures up to 900°C, such as tight surfaces on fittings, valve seats and cones for combustion engines, gliding surfaces metal-metal, highly stressed hot working tools without thermal shock, milling mixers and drilling tools. Excellent gliding characteristic, easy polishability, good toughness, nonmagnetic, machining by grinding or with tungsten carbide cutting tools.

WELDING INSTRUCTIONS:

- Clean welding area
- Preheating temperature 450 - 600°C
- Very slow cooling.
- Hold electrode vertically and with a short arc and lowest possible amperage.
- Re-dry electrodes that have become damp for 2 h / 300°C

PACKING PARAMETERS

Size (mm)	Length (mm)	Current Condition AC / DC (+) Amps	Packing / Packet (kg)	Packing / Box (kg)
3.15 / 3.20	350	70 - 110	2	2 x 5 = 10
4	350	90 - 130	2	2 x 5 = 10
5	350	110 - 150	2	2 x 5 = 10