

# GM ST6

## IDENTIFICATION

GM ST-6, ERCCOCr-A

## CLASSIFICATION

AWS/SFA 5.21: ERCCOCr-A

## DESCRIPTION

Stellite arc wire on cobalt base, core wire alloyed. GM ST6 has excellent welding properties and a homogeneous, finely rippled seam weld metal.

## CHEMICAL 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

GM 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 2h / 300°C

**SHIELDING GAS :** 80% Argon + 20% CO<sub>2</sub>

## PACKING PARAMETERS

Size (mm)	Weight / Spool (kg)
1.2	12.5 / 15.0