DMCCO#6 -- DURAMAX COBALT #6 -- TUBLAR CORED WIRE

Classification: **ERCCoCr-A** ***Specification:*** AWS A5.21 / ASME SFA 5.21

Description:

DMCCO#6 is the tubular wire version of a cobalt alloy that produces a medium hardness cobalt-chromium deposit for high temperature applications with good abrasive wear and good impact resistance.
DMCCO#6 is the most versatile and widely used cobalt alloy. Chromium carbides contained in the deposit provide 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 include extrusion screws shafts roller bushings.

Typical Chemical Composition (%)

C	Mn	Si	Cr	Ni	Mo	Fe	W	Co
0.70 - 1.40	2.0 max	2.0 max	25.0 - 32.0	3.0 max	1.0 max	5.0 max	3.0 - 6.0	Remainder
TOE = 1.0 max								

Typical Deposit Characteristics:

- Abrasion Resistance	Excellent	- Cold Abrasion	Good
- Impact Resistance	Excellent	- Hot Abrasion	Good
- Erosion Resistance	Excellent	- Deposit Layers	2 Layers
- Corrosion Resistance	Excellent	- Machinability	Use Carbide tools
- Hardness	HRC 42 - 45	*With Proper Preheat and Slow Cooling	

Sizes available and recommended currents

Diameter	Amps DCEP	Voltage	Shielding Gas	Wire Extension	Position
.045" (1.2mm)	180 - 200	25 - 27	Argon	1/2" - 5/8"	Flat
1/16" (1.6mm)	280 - 300	26 - 28	Argon	5/8" - 3/4"	Flat