



CEWELD E DUR 6U

TYPE Cobalt-based welding electrode for overlay applications.

APPLICATIONS CEWELD® DUR 6U is a Stellite 6 alloy with excellent properties against abrasion, thermal shock and corrosion in conjunction with high temperatures. It produces a high-quality armoring on components that are exposed to multiple stresses from erosion, corrosion, cavitation, pressure, impact, abrasion and high temperatures up to 900 °C,
For example: sealing surfaces on fittings, valve seats and cones for combustion engines, metal-to-metal sliding surfaces, highly stressed hot working tools without thermal shock, grinding, stirring and drilling tools. drilling tools.

PROPERTIES CEWELD® DUR 6U has excellent welding properties and self-releasing slag. The weld metal can be machined with carbide tools and by grinding. The hardness of the weld metal decreases by 16 % at 300 °C and by around 30 % at 600 °C. The weld metal is highly heat-resistant up to 900 °C.
Hardness of the pure weld metal: 40 - 42 HRC
Hot hardness at 500 °C: approx. 30 HRC
Hot hardness at 700 °C: approx. 160 HB

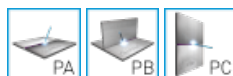
CLASSIFICATION

AWS	A 5.13: E CoCr-A
EN ISO	14700: E Co2
DIN	8555: E 20-UM-40- CTZ
F-nr	71

SUITABLE FOR Steam-valves, High temperature liquid pumps, Hot cutting tools, Exhaust valves, Pumps, Plastic recycling etc.

APPROVALS

WELDING POSITIONS



TYPICAL CHEMICAL ANALYSIS OF WELD METAL (%)

C	Si	Mn	Fe	W	Cr	Co
1.1	1	0.6	2.5	4.5	28	Rem.

MECHANICAL PROPERTIES

Heat Treatment	R _{P0.2} (MPa)	R _m (MPa)	A5 (%)	Hardness
As Welded				42 HRc

REDRYING 300°C / 2 hr

GAS ACC. EN ISO 14175



CEWELD E DUR 6U

E DUR 6U 2,5 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663402097

E DUR 6U 3,2 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663402103

E DUR 6U 4,0 X 350MM

Packaging	KG/unit	EanCode
Can	2,8	8720663402110