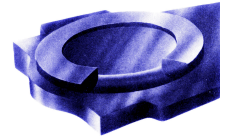


SHUBER E 806

WEARFACING - COBALT BASE ALLOY



DESCRIPTION

COBALT BASE ELECTRODE DEVELOPED FOR OVERLAYS HIGHLY RESISTANT TO METAL-TO-METAL WEAR AT HIGH TEMPERATURES. Cobalt-chromium-tungsten alloy provides deposits with exceptional wear resistance at temperatures up to 800°C(1472°F). Excellent for applications subjected to thermal cycling, high temperature corrosion and oxidation. Ideally suited for protective overlays on valves and valve seats, hot shear blades, hot trimmers and press forming dies.

SPECIAL FEATURES

- Scaling resistant up to 975°C(1787°F).
- Corrosion resistant to mostly used acids.
- High metal recovery (150%).

APPLICATION INSTRUCTIONS

Clean weld area of oil, grease and oxides. Preheat is usually not required but preheating to 300°C(572°F) is recommended for hardened steels. Maintain a short arc and deposit stringer beads or slight weaving. After welding, slow cooling is necessary.

TECHNICAL DATA

HARDNESS : 40 - 43 HRC

RECOMMENDED CURRENT: DIAMETER AC or DC (Reverse Polarity)	AMPS
3.2 mm (1/8")	90 - 125
4.0 mm (5/32")	120 - 160

Tip Colour: Silver

Available Coated (E 806) or Bare (G 806)

DIN 8555:
E 20 - 45 ctz