

# CARBO S 6

## Standards

AWS A5.13	ECoCr-A
DIN 8555	E20-UM-40-CTZ

## Approvals

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## Characteristics

CARBO S 6 is a coated electrode for welding on DC as well as on AC. The deposit is a cobalt base alloy with an austenitic-leadburitic structure.

The weld metal has a great resistance to corrosion, impact and abrasive wear as well as to metal-metal wear.

Ductility and ruggedness of the weld metal gives exceptional thermo-shock resistance and resistance to heavy mechanical impact.

The alloy is machinable.

CARBO S 6 is used on steam- and chemical valves and on equipment handling hot steel, such as tong-bits, shear-blades, pumps for high temperature liquids.

## Operating temperature

From room temperature up to + 600° C

## Typical applications

Working temperature should be chosen depending on base material and construction. For low alloyed steels and austenitic steels a slow cooling rate is advisable.

## Mechanical properties of all-weld metal

( typical values )

Hardness at Room temperature HRC	+ 600° C HRC	+ 800° C HRC
approx. 42	approx. 35	approx. 29

## Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	W	Fe	Co	Other
1	0,9	1	28	4,5	3	Base	< 3

## Current

= + / ~, 42 V

## Welding positions

PA, PB, PC

## Rebaking

1 h, 350 + / - 10 °C ( if required )

## Flux-cored wire equivalent

CARBO F-S 6

## Dimensions Current intensity No. of pieces/net weights (typical values)

Dia./Length	Amperage (A)	Pcs./packet	Pcs./carton	Kg/1000 pcs.	Kg/packet	Kg/carton
2,5 x 350	50 - 90	145	580	34,5	5,0	20,0
3,2 x 350	90 - 130	84	336	59,5	5,0	20,0
4,0 x 350	120 - 170	62	247	81,0	5,0	20,0
5,0 x 350	150 - 200	38	152	131,2	5,0	20,0