



Manufacturers of Custom Welding Lines for Resale
www.selectrode.com

SELECTRODE 1206

Cobalt Grade 6 Electrode

INTERNATIONAL CLASSIFICATIONS

AWS/ASME A 5.13 E CoCr-A
DIN 8555: E20-UM-45-CRTZ

EN 14700 E Co2

FEATURES & APPLICATIONS

For moderate abrasion resistance combined with resistance to corrosion, erosion and thermal shock.

Extremely smooth running Alloy 6 Cobalt electrode

- Controlled weld bead allows for easy edge buildups.
- Slag is self releasing.
- Weld deposits are unusually fine rippled and uniform.
- Available bare as product code 1296.
- Special technology also performs on AC current.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

Microstructure: Cobalt based austenite with some carbides and other complex phases.

Flux Color: Grey

Tip Color: Silver

C	Mn	Si	Cr	Fe	Mo	Ni	W	Co
1.2	.8	1.0	30	2	.5	3	6	Bal.

TYPICAL MECHANICAL PROPERTIES

Undiluted Weld Metal

Maximum Value Up to:

Hardness

Room Temperature: 68°F (20°C)

Rockwell C45

Work Hardened

Rockwell C55

Elevated Temperatures: 750°F (400°C)

Rockwell C32

1110°F (600°C)

Rockwell C28

1475°F (800°C)

Rockwell C22

1620°F (900°C)

Rockwell C20

WELDING CURRENT & INSTRUCTIONS

Recommended Current: AC or DC Reverse (+)

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	65	80	100
Maximum Amperage	85	110	130

Welding Techniques: Preheat massive parts to 570°F (300°C). Minimize amperage during welding.

Welding Positions: Flat, horizontal

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrode	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition min/lb (kg)	Amperage Settings	Recovery Rate
3/32 (2.5)	14" (350)	.80 oz. (22g)	20 (44)	19 (42)	75	130%
1/8 (3.25)	14"(350)	1.2 oz (33g)	13 (29)	14 (31)	95	130%
5/32 (4.0)	14" (350)	1.56 oz (44g)	10 (22)	11 (24)	115	130%

APPROXIMATE ELECTRODE PACKAGING & DIMENSIONS

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Length (mm)	14" (350)	14" (350)	14" (350)
Electrodes / lb	18	11	7
Electrodes / kg	40	25	16