

## SUPERALLOY 1006

Finest alloy available for high temperature service. Special cobalt base formulation assures combination characteristics of high hardness (RC 40-44) edge retention property and resistance to softening at high temperature. Compressive stress deformation, abrasion and friction (especially galling seizing). Resists corrosion at elevated temperature. Non magnetic, non heat-treatable, good weldability. Deposits can be machined using carbide tipped tools or by grinding.

### Applications:

For super-conditioning of valves, Hot punches, Ingot Tongs, Wire Drawing Blocks, Charging rams. Hot shear blades. Edger rolls, Exhaust valves and seats. Hot trim dies and swaging mandrels.

### Procedure:

Clean surface by grinding, use electrode AC/DC+. Hold short arc and deposit stringer beads. Use backstep and staggered welding sequence. Chip slag between passes.

<b><u>Technical Data</u></b>	<b>:</b>	<b>SUPERALLOY 1006</b>			
Size (mm), Ø	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	50-85	70-110	100 – 140	140-180
Hardness (As Deposited)	:	40-44 HRC			
Tensile Strength	:	85 kgf / mm <sup>2</sup>			
Yield Strength	:	160 kgf / mm <sup>2</sup>			

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