

POSTALLOY® 2506-SPL (Cobalt 6)



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Description

Conforms to AWS CoCr-A. Cobalt base alloy with excellent resistance to mechanical wear and corrosion over a wide temperature range. It retains an effective hardness even up to 820°C. Offers outstanding self-mating, anti-galling properties and it is effective when abrasion is accompanied by thermal shock or impact. Deposits are machinable. Crack-free deposits can be made with proper preheat, post heat and interpass temperature.

Specifications

Product Type: COBALT BASE
HARDFACING ALLOYS
METAL - CORED, GAS - SHIELDED

Weld Deposit Properties

Average hardness: 40-45 Rc
Deposit thickness: 2 layers
Deposits are machinable

POSTALLOY® 2506-SPL Welding Parameters

Current: Use DC Reverse (+) Polarity

Short Arc	Amps	Volts	Gas	L/min
1.2mm	80-160	15-23	Ar/CO ₂	18-22
Spray Arc	Amps	Volts	Gas	L/min
1.2mm	170-240	24-30	Ar/Ox	18-22

These wires operate over a wide range of settings and can be used in short-arc and spray transfer. CO₂ shielding gives the best control, but the most dilution and lowest hardness on first pass. Argon/CO₂(75/25) gives good control, a better bead appearance and higher first pass hardness. Spray-arc produces minimal dilution and high first pass hardness.

Packaging Options

Diameter	Standard Packaging
1.2mm	2.27kg spool

Diam.	2.27 kg Spool
1.2mm	PHF250612

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