

**CODING:****EURO STELLT - 1**

ASME:11C SFA 5.13 E CoCr-C

**CHARACTERISTICS:**

Euro Stellt-1 is a Cobalt alloy electrode specially designed for building up of part subject to separate or combined action of heavy abrasive wear or metal to metal wear at elevated temperature and in corrosive media. Electrode is further characterized by excellent operational features, smooth and stable arc which is easy to strike and restrike, good slag detachability and finely rippled bead of good profile.

**APPLICATIONS:**

Euro Stellt-1 is recommended for overlay applications where excellent resistance to high temperature wear, corrosion and abrasion is required. Some of the typical applications include, Rotating Fans of Boilers, Roller mill guides, Steam turbine parts, valve seats, extrusion dies and mixer blades.

**CHEMICAL COMPOSITION OF WELD METAL(TYPICAL):**

Element	C	Cr	W	Co	Si	Mn	Fe	Ni
Percent	3-5	33	15.5	Balance	1.5	1	3.00 – 4.00	1.5

**TYPICAL WELD METAL HARDNESS:**

Hardness (as welded) : 58/62 HRC

**WELDING PROCEDURE:**

1. Ensure that the surface is free from water, rust, scale, grease of any foreign matter.
2. Depending on the size of workpiece, preheat to temperatures from 150°C to 300°C.
3. Use short arc and stringer beads, as far as possible.
4. In case of build up limited to one layer or two layers, employ welding currents as low as possible consistent with proper fusion and weld bead formation. This is meant to control dilution of weld metal.
5. Allow the workpiece to cool slowly after building up.
6. Redry, if found necessary, electrodes for one hour at 250°C and then transfer to a holding oven maintained at 60°C to 80°C, before taking up for use.

**PACKING SPECIFICATION AND CURRENT DATA: DC(+) OR AC 80V.**

Size (DxL)mm	3.15 x 350	4.00 x 350	5.00 x 350
Current(Amps)	90-125	130-160	160-190