

WELDING ELECTRODES

Deloro Stellite manufactures rutile, all directional electrodes in the following diameters.

- 2.6 mm (3/32")
- 3.2 mm (1/8")
- 4.0 mm (5/32")
- 5.0 mm (3/16")
- 6.4 mm (1/4")

Electrodes are supplied in lengths of 350mm (14") and are boxed in 5.0kg (11 lb) plastic, sealed boxes.

Please see table below for information on our alloys available in electrode form.

ALLOY	NOMINAL ANALYSIS OF UNDILUTED WELD METAL ¹									UNS	ASME/ AWS ²	Hardness (HRC) ³
	Co	Cr	W	C	Ni	Mo	Fe	Si	Other			
COBALT BASE ELECTRODES												
Stellite 1	Bal.	31	12	2.45	<3.0	<1.0	<3.0 0	<2.0 0	<1.0	W730 01	(SF)A 5.13 ECoCr- C	51-56
Stellite 6	Bal.	29	4	1.2	<3.0	<1.0	<3.0 0	<2.0 0	<1.0	W730 06	SFA 5.13 ECoCr- A	39-43
Stellite 12	Bal.	30	8	1.4- 1.8	<3.0	<1.0	<3.0 0	<2.0 0	<1.0	W730 12	(SF)A 5.13 ECoCr- B	45-50
Stellite 20	Bal.	32	16	2.45	<3.0	<1.0	<3.0 0	<2.0 0	<1.0	-	-	53-57
Stellite 21	Bal.	28	-	0.25	3	5.5	<3.0 0	<1.5 5	<1.0	W730 21	(SF)A 5.13 ECoCr- E	28-40 *
Stellite 25	Bal.	20	14	0.1	10	<1.0	<3.0	<1.0	<1.0	-	-	20-45 *

- ¹ Nominal analysis is a guideline only for standard product, does not include all incidental elements and may differ depending on the exact specification/standard used when ordering.
- ² When written certification to a standard is required, please specify this when ordering. Certain products can also be certified to AMS, SAE and other standards. Please contact us for more details.
- ³ Undiluted weld metal

ALLOY	NOMINAL ANALYSIS OF UNDILUTED WELD METAL ¹									UNS	ASME/ AWS ²	Hardness (HRC) ³
	Co	Cr	W	C	Ni	Mo	Fe	Si	Other			
							0	0				
Stellite 250	Bal.	28	-	0.1	-	-	21	<1. 0	<1.0	-	-	20-28
Stellite 306	Bal.	24	3	0.5	6	-	4	1	6% Nb	-	-	32-42 *
Stellite 706	Bal.	30	-	1.2	<3.0	4	<3. 0	<1. 0	<1.0	-	-	39-44
Stellite 712	Bal.	30	-	1.5/1. 9	<3.0	8	<3. 0	<2. 0	<1.0	-	-	46-51
ULTIMET	Bal.	26	2	0.06	9	5	3		<1.0	-	-	28-45 *
NICKEL BASE ELECTRODES												
Nistelle C	-	17	5	0.1	Bal.	17	6	-	0.3% V	W800 02	-	17-27 *