

## CORED WELDING WIRE

Deloro Stellite manufactures flux cored MIG wire. The wire is available in the following standard diameters:

- 1.2 mm (0.045”) – supplied in 15kg (33lb) spools
- 1.6 mm (0.062”) – supplied in 15kg (33lb) spools
- 2.4 mm (0.093”) – typically supplied in 25kg (55lb) spools (optionally in 15kg spools)
- 3.2 mm (0.126”) (special order) – supplied in 25kg (55lb) spools

Please see table below for details of our alloys available in wire form.

ALLOY	NOMINAL ANALYSIS OF UNDILUTED WELD METAL <sup>1</sup>								Other s	UNS	ASME/ AWS <sup>2</sup>	Hardnes s (HRC) <sub>3</sub>
	Co	Cr	W	C	Ni	Mo	Fe	Si				
<b>COBALT BASE ALLOY CORED WIRE</b>												
Stellite 1	Bal.	28	11.5	2.45	<3.0	<1.0	<5.0	<2.0	<1.0	W73031	(SF)A 5.21 ERCCoCr-C	50-55
Stellite 6	Bal.	30	4.5	1.2	<3.0	<1.0	<5.0	<2.0	<1.0	W73036	SFA 5.21 ERCCoCr-A	38-44
Stellite 12	Bal.	29	8	1.4-1.8	<3.0	<1.0	<5.0	<2.0	<1.0	W73042	(SF)A 5.21 ERCCoCr-B	45-50
Stellite 21	Bal.	28	-	0.25	3	5.2	<5.0	<1.5	<1.0	W73041	(SF)A 5.21 ERCCoCr-E	28-40 *
Stellite 21LC	Bal.	26	-	0.1	4	6.0	<5.0	<1.5	<1.5		Proprietary crack resistant alloy specially developed for hardfacing of forging dies.	25-40 *
Stellite 25	Bal.	20	14	0.1	10	<1.0	<3.0	<1	<1.0	-	-	20-45 *
Stellite 250	Bal.	28	-	0.1	-	-	21	<1	<1.0	-	-	20-28
Stellite 306	Bal.	25	2-3	0.5	6	-	6	1	6% Nb	-	-	32-42 *
Stellite 706	Bal.	31	-	1.2	<3.0	4	<3.0	<1	<1.0	-	-	39-44
Stellite 712	Bal.	31	-	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	R31233	-	28-45 *
<b>NICKEL BASE ALLOY CORED WIRE</b>												
Nistelle C	-	17	5	0.1	Bal.	17	6	-	0.3% V	N30002	-	17-27 *
Deloro 40	-	10	-	0.4	Bal.	-	2-3	2.9	1.6% B	W89634	(SF)A 5.21 ERNiCr-A	35-40

<sup>1</sup> 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.

<sup>2</sup> 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.

<sup>3</sup> Undiluted weld metal. Please note that the hardness of the “Deloro” Ni-based alloys is very sensitive to dilution.

ALLOY	NOMINAL ANALYSIS OF UNDILUTED WELD METAL <sup>1</sup>								Other s	UNS	ASME/ AWS <sup>2</sup>	Hardnes s (HRC) <sub>3</sub>
	Co	Cr	W	C	Ni	Mo	Fe	Si				
Deloro 50	-	12	-	0.5	Bal.	-	3-5	3.5	2.2% B	W89635	(SF)A 5.21 ERNiCr-B	47-52
Deloro 60	-	13		0.7	Bal.		3-5	4.3	3.0% B	W89636	(SF)A 5.21 ERNiCr-C	56-61
INTER-METALLIC LAVES PHASE ALLOY CORED WIRE (TRIBALLOY <sup>®</sup> ALLOYS)												
T-401	Bal.	17	-	0.2	<1.5	22	<1.5	1.3	-	-	-	46-52