

ULTIMET[®] X Coated Electrodes

Product Description:

ULTIMET[®] X coated electrodes are used for the shielded metal arc welding of ULTIMET[®] alloy. The deposit weld metal has exceptional resistance to galling, cavitation erosion, slurry erosion, liquid droplet impact, and various forms of corrosive attack. ULTIMET[®] alloy exhibits superior weldability and may be used to weld overlay carbon and stainless steels to improve their resistance to corrosion-wear. The deposit can be made easily without experiencing cracking issues common to competing alloys.

Specifications:

HAYNES PS-6041-1

Composition:

Cobalt:	Balance	Silicon:	0.05-1.00
Chromium:	23.50-27.50	Other:	0.50 max.
Nickel:	7.00-11.00	Nickel:	0.03-0.14
Molybdenum:	4.00-6.00	Carbon:	0.02-0.10
Iron:	1.00-5.00	Phosphorus:	0.030 max.
Tungsten:	1.00-3.00	Sulfur:	0.020 max.
Manganese:	0.10-1.50		

Minimum Mechanical Properties:

Tensile (psi)	-
Mpa	-
Elongation (%)	-

Available Product Forms and Sizes:

Diameter in	0.093	0.125	0.156	0.187
Diameter mm	2.40	3.20	4.00	4.70
Length in	10	14	14	14
Length mm	254	355.6	355.6	355.6
Package Weight lbs.	5	10	10	10
Current (A) DCEP	40-70	70-100	80-140	120-150