

# Cobalarc Hardfacing Electrodes

## Cobalarc 650

HV<sub>30</sub>  
640

55  
ocv

AC  
DC



- Metal Enriched, Rutile Type Electrode.
- For Re-building or Surfacing Worn Steel Components.
- Air Hardening, Crack Free, Martensitic Steel Deposit.
- Typical applications include the surfacing of agricultural points, shares and tynes, grader and dozer blades, conveyor screws and post hole augers etc.

**Typical All Weld Metal Deposit Analysis:**  
C: 0.58% Mn: 1.1% Si: 0.6%  
Cr:5.3% Mo: 0.25%

**Finishing Recommendations:**  
Not machinable - Grinding only

**Typical Weld Deposit Hardness:**

	HRC	HV30
Single layer on mild steel	55	600
All weld metal deposit	57	640

**Comparable CIGWELD products:**  
Stoody 965 G/O tubular wire  
AS/NZS 2576: 1855-B5/B7  
  
Stoody 850-O tubular wire  
AS/NZS 2576: 1865-B5/B7

### Classifications:

AS/NZS 2756: 1855-A4  
WTIA Tech. Note 4: 1855-A4

### Packaging and Operating Data:

Electrode		Approx No.	Current	Packet	Carton	Part No
Size mm	Length mm	Rods/kg	Range (amps)			
3.2	380	31	105 – 135	5kg	15kg - 3 x 5kg	611463
4.0	380	21	140 – 180	5kg	15kg - 3 x 5kg	611464

AC (minimum 55 OCV) DC+ or DC- polarity.

## Cobalarc 750

HV<sub>30</sub>  
800

45  
ocv

AC  
DC



- Rutile type, AC/DC Hard Surfacing Electrode.
- Easy Arc Starting and Stable Running on Portable AC Welding Sets (45 O.C.V.).
- Air Hardening, Crack Free, Martensitic Steel Deposit.
- Typical applications include the surfacing of agricultural equipment and components including points, shares, post hole augers, rupper teeth & tynes etc.

NOTE: 3.2mm & 4.0mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.

**Typical All Weld Metal Deposit Analysis:**  
C: 0.60% Mn: 0.46% Si: 0.75%  
Cr:5.9% Mo: 0.40%

**Finishing Recommendations:**  
Not machinable - Grinding only

**Typical Weld Deposit Hardness:**

	HRC	HV30
Single layer on mild steel	64	800
Two layers on mild steel*	62	750

**Comparable CIGWELD products:**  
Cobalarc 650 manual arc electrode  
AS/NZS 2576: 1855-A4  
  
Stoody 965 G/O tubular wire  
AS/NZS 2576: 1855-B5/B7

\*Not recommended for multi-pass welding heavier than 3 layers

Stoody 850-O tubular wire  
AS/NZS 2576: 1865-B5/B7

### Classifications:

AS/NZS 2756: 1860-A4  
WTIA Tech. Note 4: 1860-A4

### Packaging and Operating Data:

Electrode		Approx No.	Current	Packet	Carton	Part No
Size mm	Length mm	Rods/kg	Range (amps)			
3.2	380	26	95 – 130	5kg	15kg - 3 x 5kg	611473
4.0	380	17	120 – 170	5kg	15kg - 3 x 5kg	611474

### Easyweld Blister Pack:

10 x 3.2mm rod Cobalarc 750 Blister Pack 322218

AC (minimum 45 OCV) DC+ or DC- polarity.

## Cobalarc Toolcraft

HV<sub>30</sub>  
700

55  
ocv

AC  
DC



- Versatile Manual Arc Welding Electrode.
- Secondary Hardening, Shock Resistant Properties.
- Crack Free Cr-Mo Steel Deposit for Repairing Blades, Dies, Punches etc.
- Also Suitable for General Hard Surfacing in Low Stress Abrasion Conditions.

NOTE: 3.2mm size can be used for vertical welding by depositing overlapping horizontal stringer passes.

**Typical All Weld Metal Deposit Analysis:**  
C: 0.58% Mn: 0.10% Si: 0.20%  
Cr:5.5% Mo: 6.8%

**Finishing Recommendations:**  
Not machinable - Grinding only

**Typical Weld Deposit Hardness:**

	HRC	HV30
Single layer on mild steel	55	600
All weld metal deposit	60	700

### Classifications:

AS/NZS 2756: 1560-A4  
WTIA Tech. Note 4: 1560-A4

### Packaging and Operating Data:

Electrode		Approx No.	Current	Packet	Carton	Part No
Size mm	Length mm	Rods/kg	Range (amps)			
2.5	300	58	65 – 90	20 rod	–	322115
3.2	380	28	90 – 125	5kg	15kg - 3 x 5kg	611523

AC (minimum 55 OCV) DC+ or DC- polarity.