Cobalarc Hardfacing Electrodes

Cobalarc 650

HV30 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 te surfacing of agricultural points, shares and tynes, grader and dozer blades, conveyor screws and post hole augers etc.

Classifications:

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

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

Typical Weld Deposit Hardness:

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

Finishing Recommendations:
Not machinable - Grinding only

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

Packaging and Operating Data:

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
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 (miniumum 55 OCV) DC+ or DC- polarity.

Cobalarc 750

HV30 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.

Classifications:

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

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

Typical Weld Deposit Hardness:

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

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

Finishing Recommendations:
Not machinable - Grinding only

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

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

Packaging and Operating Data:

Electrode Size mm	Electrode Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
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 (miniumum 45 OCV) DC+ or DC- polarity.

Cobalarc Toolcraft

HV30 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.

Classifications:

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

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

Typical Weld Deposit Hardness:

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

Finishing Recommendations:
Not machinable - Grinding only

Packaging and Operating Data:

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

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