

# Cobalarc Hardfacing Electrodes

## Cobalarc Austex

HV<sub>30</sub>  
400

50  
ocv

AC  
DC



- Metal Enriched, Rutile Type Electrode.
- For Joining Dissimilar steels or as a Buffer Layer Prior to Hard Surfacing.
- Tough, Machinable Austenitic Stainless Steel Deposit.

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

**Typical All Weld Metal Deposit Analysis:**  
C: 0.10% Mn: 1.50% Si: 0.90%  
Cr:24.5% Ni: 9.3%

**Finishing Recommendations:**  
Machinable with carbide tools

**Typical Weld Deposit Hardness:**

	HRC	HV30
All weld metal deposit	20	240
Hardness	40	400

### Classifications:

AS/NZS 2756: 1315-A4  
WTIA Tech. Note 4: 1315-A4

### Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
3.2	380	20	105 – 140	5kg	15kg - 3 x 5kg	613973
4.0	380	13	140 – 180	5kg	15kg - 3 x 5kg	613974
5.0	450	7	170 – 210	5kg	15kg - 3 x 5kg	613975

AC (minimum 50 OCV) DC+ or DC- polarity.

## Cobalarc Mangcraft

HV<sub>30</sub>  
425

55  
ocv

AC  
DC



- Austenitic Manganese Steel Electrode.
- For Building Up & Reinforcing 11-14% Manganese Steels.
- Tough and Impact Resistant Weld Deposit.
- Work Hardens Under Heavy Impact.

**Typical All Weld Metal Deposit Analysis:**  
C: 0.60% Mn: 12.0% Si: 0.10%

**Finishing Recommendations:**  
Machinable with carbide tools

**Typical Weld Deposit Hardness:**

	HRC	HV30
All weld metal deposit	15	–
Hardness	43	425

**Comparable CIGWELD products:**  
Stoody Dynamang-0 tubular wire

### Classifications:

AS/NZS 2756: 1215-A4  
WTIA Tech. Note 4: 1215-A4

### Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
4.0	380	17	130 – 170	5kg	15kg - 3 x 5kg	611504
5.0	450	10	150 – 200	5kg	15kg - 3 x 5kg	611505

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

## Cobalarc 350

HV<sub>30</sub>  
350

55  
ocv

AC  
DC



- Metal Enriched, Rutile Type Electrode.
- For Re-building Worn Steel Components.
- Tough, Machinable Low Carbon Martensitic Steel Deposit.
- For the manual arc build-up and surfacing of steel gear, shafts, rails, shovel pads, track links, rolls and wheels etc.

NOTE: 3.2mm and 4.00mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.

**Typical All Weld Metal Deposit Analysis:**  
C: 0.07% Mn: 0.85% Si: 0.30%  
Cr:1.85% Mo: 0.5%

**Finishing Recommendations:**  
Machinable

**Typical Weld Deposit Hardness:**

	HRC	HV30
Single layer on mild steel	28	290
All weld metal deposit	35	350

**Comparable CIGWELD products:**  
Stoody Super Build-up G/O tubular wire  
AS/NZS 2576: 1435-B5

### Classifications:

AS/NZS 2756: 1435-A4  
WTIA Tech. Note 4: 1435-A4

### Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
3.2	380	26	100 – 150	5kg	15kg - 3 x 5kg	611443
4.0	380	17	140 – 200	5kg	15kg - 3 x 5kg	611444

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