



## COBALARC 650

HV<sub>30</sub>  
64055  
OCVDC  
AC

## 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	HV <sub>30</sub>
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	57	640

## FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

## COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650-G tubular wire  
AS/NZS 2576: 1855-B5/B7  
Cobalarc 850-O tubular wire  
AS/NZS 2576: 1865-B7

- ▲ 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.

## Classifications:

AS/NZS 2576: 1855-A4.  
W.T.I.A. Tech. Note 4: 1855-A4.

## Packaging and Operating Data:

AC (minimum 55 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	No. of Electrodes per kg.	Current Range (amps)	Packet		Part No
				5kg	12kg	
3.2	380	31	105 – 135	15kg – 3 x 5kg	611463	
3.2	380	31	105 – 135	1kg	12kg – 12 x 1kg	610463
4.0	380	21	140 – 180	15kg – 3 x 5kg	611464	
4.0	380	21	140 – 180	1kg	12kg – 12 x 1kg	610464

## COBALARC 750

HV<sub>30</sub>  
80045  
OCVAC  
DC+

## 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	HV <sub>30</sub>
Single Layer on Mild Steel	64	800
Two Layers on Mild Steel*	62	750

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

## COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650 manual arc electrode  
AS/NZS 2576: 1855-A4  
Cobalarc 650-G/O tubular wire  
AS/NZS 2576: 1855-B5/B7  
Cobalarc 850-O tubular wire  
AS/NZS 2576: 1865-B7

## FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.  
  
3.2mm and 4.0mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.

- ▲ 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, rubber teeth & tynes etc.

## Classifications:

AS/NZS 2576: 1860-A4.  
W.T.I.A. Tech. Note 4: 1860-A4.

## Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	No. of Electrodes per kg.	Current Range (amps)	Packet		Part No
				5kg	12kg	
3.2	380	26	95 – 130	15kg – 3 x 5kg	611473	
3.2	380	26	95 – 130	1kg	12kg – 12 x 1kg	610473
4.0	380	17	120 – 170	15kg – 3 x 5kg	611474	
4.0	380	17	120 – 170	1kg	12kg – 12 x 1kg	610474

Easyweld Blister Pack:

10 x 3.2mm rod Cobalarc 750 Blister Pack 322218

## COBALARC TOOLCRAFT

HV<sub>30</sub>  
70055  
OCVAC  
DC+

## 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	HV <sub>30</sub>
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	60	700

## FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

- ▲ 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 2576: 1560-A4.  
W.T.I.A. Tech. Note 4: 1560-A4.

## Packaging and Operating Data:

AC (minimum 45 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	No. of Electrodes per kg.	Current Range (amps)	Packet		Part No
				5kg	12kg	
3.2	380	28	90 – 125	15kg – 3 x 5kg	611523	