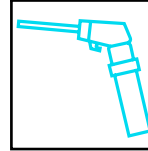


# WELDING CONSUMABLES

## COBALARC HARDFACING CONSUMABLES



## SECTION THREE

### COBALARC AUSTEX

HV<sub>30</sub>  
40050  
OCVDC  
AC
**TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:**

C: 0.10% Mn: 1.50% Si: 0.90%  
Cr: 24.5% Ni: 9.3%

**TYPICAL WELD DEPOSIT HARDNESS:**

	HRC	HV <sub>30</sub>
All Weld Metal Deposit	20	240
Work Hardened Deposit	40	400

**FINISHING RECOMMENDATIONS:**

Machinable with Carbide Tools

- ▲ 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.

**Classifications:**

AS/NZS 2576: 1315-A4.  
W.T.I.A. Tech. Note 4: 1315-A4.

**Packaging and Operating Data:**

AC (50 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	No. of Electrodes per 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

### COBALARC MANGCRAFT

HV<sub>30</sub>  
42555  
OCVDC  
AC
**TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:**

C: 0.60% Mn: 12.0% Si: 0.10%

**TYPICAL WELD DEPOSIT HARDNESS:**

	HRC	HV <sub>30</sub>
All Weld Metal Deposit	15	---
Work Hardened Deposit	43	425

**FINISHING RECOMMENDATIONS:**

Machinable with Carbide Tools.

**COMPARABLE CIGWELD PRODUCTS:**

Cobalarc Mang Nickel-O tubular wire  
AS/NZS 2576: 1215-B7

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

**Classifications:**

AS/NZS 2576: 1215 - A4.  
W.T.I.A. Tech. Note 4: 1215 - A4.

**Packaging and Operating Data:**

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

Electrode Size mm	Length mm	No. of Electrodes per 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

### COBALARC 350

HV<sub>30</sub>  
35055  
OCVDC  
AC
**TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:**

C: 0.07% Mn: 0.85% Si: 0.30%  
Cr: 1.85% Mo: 0.5%

**TYPICAL WELD DEPOSIT HARDNESS:**

	HRC	HV <sub>30</sub>
Single Layer on Mild Steel	28	290
All Weld Metal Deposit	35	350

**FINISHING RECOMMENDATIONS:**

Machinable.

**COMPARABLE CIGWELD PRODUCTS:**

Cobalarc 350-G, O tubular wire  
AS/NZS 2576: 1435-B5/B7

- ▲ 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.

**Classifications:**

AS/NZS 2576: 1435-A4.  
W.T.I.A. Tech. Note 4: 1435-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	Carton	Part No
3.2	380	25	100 – 150	5kg	15kg – 3 x 5kg	611443
3.2	380	25	100 – 150	1kg	12kg – 12 x 1kg	610443
4.0	380	16	140 – 200	5kg	15kg – 3 x 5kg	611444
4.0	380	16	140 – 200	1kg	12kg – 12 x 1kg	610444