

# Cobalarc Hardfacing Electrodes

## Cobalarc 1e

HV<sub>30</sub>  
700

55  
ocv

AC  
DC+



- Highly Alloyed Extruded Electrode.
- High Chromium Carbide Iron Deposit.
- Ideal for Coarse Abrasion and Low to Moderate Impact Loading.
- For wear resistant overlays on austenitic manganese steels.

### Classifications:

AS/NZS 2756:	2360-A4
WTIA Tech. Note 4:	2360-A4

### Typical All Weld Deposit Analysis:

C: 5.00% Mn: 1.10% Si: 1.3%  
Cr: 35.0%

### Typical Weld Deposit Hardness:

	HRC	HV <sub>30</sub>
Single layer on mild steel	58	660
All weld metal deposit	61	730

Deposits contain complex Chromium Carbides with hardness up to 1,500 HV.

**Finishing Recommendations:**  
Grinding only

### Comparable CIGWELD products:

Cobalarc CR70 extruded electrode  
AS/NZS 2576: 2355-A4  
Stoody 100 HC-G/O tubular wire  
AS/NZ 2576: 2360-B7

### Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
4.0	380	10	130 – 190	5kg	15kg - 3 x 5kg	613210
5.0	450	5	170 – 260	5kg	15kg - 3 x 5kg	613235

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

## Cobalarc 9e

HV<sub>30</sub>  
780

55  
ocv

AC  
DC+



- Highly Alloyed Extruded Electrode.
- Versatile, Complex Carbide Iron Deposit.
- Resistant to both Coarse and Fine Abrasion and Moderate to Heavy Impact Loading.
- Typical applications include the hard surfacing of railway ballast tampers, dredge buckets and lips, earth moving equipment, power shovels, rolling mill guides, sizing screens, ripper teeth and crushing equipment.

### Classifications:

AS/NZS 2756:	2460-A4
WTIA Tech. Note 4:	2460-A4

### Typical All Weld Deposit Analysis:

C: 4.8% Mn: 1.1% Si: 1.4%  
Cr: 30.0% Ni: 0.5% Mo: 1.7% V: 0.2%

### Typical Weld Deposit Hardness:

	HRC	HV <sub>30</sub>
Single layer on mild steel	58	660
All weld metal deposit	63	780

Deposits contain complex Chromium Carbides with hardness up to 1,500 HV.

**Finishing Recommendations:**  
Grinding only

### Comparable CIGWELD products:

Stoody 143-0

### Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
3.2	380	17	95 – 145	5kg	15kg - 3 x 5 kg	613350
4.0	380	10	130 – 190	5kg	15kg - 3 x 5kg	613360
5.0	450	5	170 – 260	5kg	15kg - 3 x 5kg	613370

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