

COBALARC 350

HV₃₀
35050
OCVDC
AC

- ▲ 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.

3.2mm and 4.0mm 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.

Description and Applications:

Cobalarc 350 is a metal enriched, rutile type electrode recommended for the multi-layer build-up and surfacing of steel components subjected to metal-to-metal wear and compressive loading.

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:

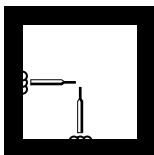
	HRC	HV ₃₀
Single Layer on Mild Steel	28	290
All Weld Metal Deposit	35	350

FINISHING RECOMMENDATIONS:

Machinable.

COMPARABLE CIGWELD PRODUCTS:

Stoody Super Build up-O tubular wire
AS/NZS 2576: 1435-B5/B7



Downhand & Horizontal surfacing and build-up applications:-
3.2mm and 4.0mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.

Depositing a tough, air hardening low carbon martensitic steel weld deposit Cobalarc 350 is recommended for the manual arc build-up and surfacing of steel gears, shafts, rails, shovel pads, track links, rolls and wheels etc.

Packaging and Operating Data:

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

Size mm	Electrode		Current Range (amps)	Packet	Carton	Part No
	Length mm	No. of Electrodes per kg.				
3.2	380	25	100-150	5kg	15kg - 3 x 5kg	611443
4.0	380	16	140-200	5kg	15kg - 3 x 5kg	611444
4.0	380	16	140-200	1kg	12kg - 12 x 1kg	610444