

- ▲ Basic Type Manual Arc Welding Electrode.
- ▲ Resistant to Hard Particle Abrasion and Moderate Impact Loading.
- ▲ Air Hardening, Crack Free, Martensitic Steel Deposit - 650 HV₃₀

Classifications:

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

Description and Applications:

Cobalarc 650 is a basic electrode for the hard surfacing of steel components subjected to wet or dry hard particle abrasion and low to moderate impact loading.

The air hardening, low alloy steel deposit of Cobalarc 650 remains crack free on most steels under normal welding conditions and is therefore recommended for hard surfacing components subject to flexing during service.

The basic flux coating gives excellent resistance to rust, mill scale, dirt and oil on the surface being hardfaced.

Typical applications include the surfacing of agricultural points, shares and tynes, grader and dozer blades, conveyor screws and post hole augers etc.

Packaging and Operating Data:

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

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

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 ₃₀
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	57	640

FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

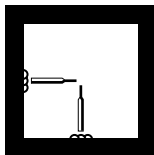
COMPARABLE CIGWELD PRODUCTS:

Stoody 965 G/O tubular wire

AS/NZS 2576: 1855-B5/B7

Stoody 850-O tubular wire

AS/NZS 2576: 1865-B7



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