

COBALARC 750

HV₃₀
80045
OCVAC
DC+

- ▲ Rutile type, AC/DC Hard Surfacing Electrode.
- ▲ Resistant to Hard Particle Abrasion.
- ▲ Air Hardening, Crack Free, Martensitic Steel Deposit - 750 HV₃₀
- ▲ Easy Arc Starting and Stable Running on Portable AC Welding Sets (≥ 45 O.C.V.).

Classifications:

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

Description and Applications:

Cobalarc 750 is a NEW smooth running, rutile type electrode specifically designed for AC hard surfacing applications in the workshop or on the land.

It gives smooth stable arcing on AC or DC welding machines and is particularly suitable for surfacing with portable AC welding sets (with ≥ 45 Open Circuit Volts) such as the CIGWELD Easywelder. Cobalarc 750 should be used with a touch welding or short arc technique and 1-2 layers are recommended for maximum deposit hardness.

When hard surfacing high carbon or low alloy steel components a buffer or buttering layer of Ferrocraft 16TXP or Ferrocraft 7016 is recommended prior to depositing Cobalarc 750.

Typical applications include the surfacing of agricultural equipment and components including points, shares, post hole augers, ripper teeth and tynes etc.

Packaging and Operating Data:

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

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

Easyweld Blister Pack:

10 x 3.2mm rod Cobalarc 750 Blister Pack	322218
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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 ₃₀
Single Layer on Mild Steel	64	800
Two Layers on Mild Steel*	62	750

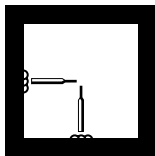
*Not recommended for multi-pass welding heavier than 3 layers

FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650 manual arc electrode
AS/NZS 2576: 1855-A4
Stoody 965-G/O tubular wire
AS/NZS 2576: 1855-B5/B7
Stoody 850-O tubular wire
AS/NZS 2576: 1865-B7



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