

Cobalarc Hardfacing Electrodes

Cobalarc Austex

HV₃₀
400

50
ocv

AC
DC



- 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.

Typical All Weld Metal Deposit Analysis:
C: 0.10% Mn: 1.50% Si: 0.90%
Cr:24.5% Ni: 9.3%

Finishing Recommendations:
Machinable with carbide tools

Typical Weld Deposit Hardness:

	HRC	HV30
All weld metal deposit	20	240
Hardness	40	400

Classifications:

AS/NZS 2756: 1315-A4
WTIA Tech. Note 4: 1315-A4

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/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

AC (minimum 50 OCV) DC+ or DC- polarity.

Cobalarc Mangcraft

HV₃₀
425

55
ocv

AC
DC



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

Typical All Weld Metal Deposit Analysis:
C: 0.60% Mn: 12.0% Si: 0.10%

Finishing Recommendations:
Machinable with carbide tools

Typical Weld Deposit Hardness:

	HRC	HV30
All weld metal deposit	15	–
Hardness	43	425

Comparable CIGWELD products:
Stoody Dynamang-0 tubular wire

Classifications:

AS/NZS 2756: 1215-A4
WTIA Tech. Note 4: 1215-A4

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/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

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

Cobalarc 350

HV₃₀
350

55
ocv

AC
DC



- 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.

Typical All Weld Metal Deposit Analysis:
C: 0.07% Mn: 0.85% Si: 0.30%
Cr:1.85% Mo: 0.5%

Finishing Recommendations:
Machinable

Typical Weld Deposit Hardness:

	HRC	HV30
Single layer on mild steel	28	290
All weld metal deposit	35	350

Comparable CIGWELD products:
Stoody Super Build-up G/O tubular wire
AS/NZS 2576: 1435-B5

Classifications:

AS/NZS 2756: 1435-A4
WTIA Tech. Note 4: 1435-A4

Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
3.2	380	26	100 – 150	5kg	15kg - 3 x 5kg	611443
4.0	380	17	140 – 200	5kg	15kg - 3 x 5kg	611444

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