

COBALARC AUSTEX
HV₃₀
400
50
OCV
DC
AC

- ▲ Metal Enriched, Rutile Type Electrode.
- ▲ For Joining Dissimilar steels or as a Buffer Layer Prior to Hard Surfacing.
- ▲ Tough, Machinable Austenitic Stainless Steel Deposit.

3.2mm size can be used for vertical welding by depositing overlapping horizontal stringer passes.

Classifications:

AS/NZS 2576: 1315-A4
 W.T.I.A. Tech Note 4: 1315-A4

Description and Applications:

Cobalarc AUSTEX is a metal enriched, rutile type extruded electrode manufactured by CIGWELD. It produces a smooth arc action and higher deposition rates than conventional stainless steel electrodes.

Deposited weld metal has high strength and toughness in combination with excellent corrosion resistance and tolerance to dilution. Under heavy impact weld deposits will work harden.

Typical applications of Cobalarc AUSTEX include the joining of dissimilar steels, in particular austenitic manganese steels or stainless steels to mild steel and deposition as a buffer layer prior to hard surfacing.

The high tolerance to dilution makes Cobalarc AUSTEX ideal for crack repairs on high carbon steel components or manganese steel castings.

TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

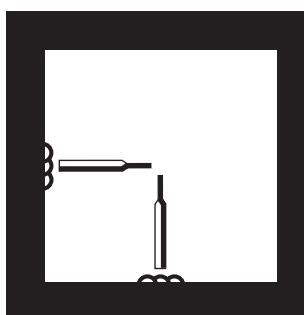
C: 0.10%	Mn: 1.50%	Si: 0.90%
Cr: 24.5%	Ni: 9.3%	

TYPICAL WELD DEPOSIT HARDNESS:

	HR _C	HV ₃₀
ALL WELD METAL DEPOSIT	20	240
WORK HARDENED DEPOSIT	40	400

FINISHING RECOMMENDATIONS:

Machinable with Carbide Tools.



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

Packaging and Operating Data:

AC (50 O.C.V.), DC+ or DC- polarity.

Electrode Size mm	Length mm	No. of Electrodes per kg	Current Range (amps)	Packet	Carton	Part No
3.2	350	20	105-140	5kg	15kg – 3 x 5kg	613973
4.0	350	13	140-180	5kg	15kg – 3 x 5kg	613974
5.0	350	7	170-210	5kg	15kg – 3 x 5kg	613975