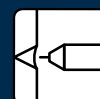


COBALARC 350-FC

PRODUCT DATA SHEET



GAS (-G) TUBULAR HARDFACING WIRE



COBALARC & STODY HARDFACING CONSUMABLES

COBALARC 350-FC

- Gas (-G) Tubular Hardfacing Wires
- Tough, Machinable Low Carbon Martensitic Steel Deposit.
- Recommended for the build-up and surfacing of steel track rolls, idler wheels, track pads, drive sprockets, pins, links and other components subject to abrasion and/or metal-to-metal wear
- 1.2mm and 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.
- 1.2mm and 1.6mm wires are B5 type wires which require a shielding gas

CLASSIFICATIONS:

1.2mm & 1.6mm

ISO AS/NZS: 2576

1435-B5

W.T.I.A. Tech Note 4:

1435-B5

TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C:	0.20%
Mn:	1.5%
Si:	0.4%
Cr:	2.0%
Mo:	0.5%

TYPICAL WELD DEPOSIT HARDNESS:

	HR _c	HV ₃₀
Single Layer on Mild Steel	30	300
All Weld Metal Deposit	40	390

DESCRIPTION AND APPLICATIONS:

Cobalarc 350-FC is a tubular hard surfacing wire designed for the re-building or surfacing of steel components subjected to metal-to-metal wear and compressive loading.

1.2mm Cobalarc 350-FC is ideal for all positional surfacing applications with Transmig 250 and 275 power plants.

Depositing a tough, air hardening low carbon martensitic steel weld deposit, Cobalarc 350-FC is recommended for the semi-automatic build-up and surfacing of steel track rolls, idler wheels, track pads, drive sprockets, pins, links and other components subjected to abrasion and/or metal-to-metal wear.

COMPARABLE CIGWELD PRODUCTS:

Cobalarc 350 extruded electrode

AS/NZS 2576: 1435-A4

RECOMMENDED SHIELDING GASES:

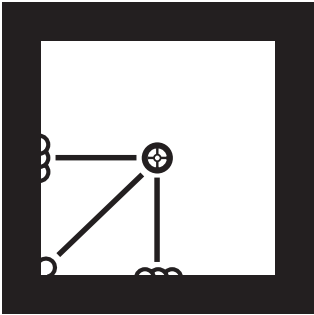
ISO14175: M13	Ar+ 1-3% O ₂
ISO14175: C1	Ar + 18-25% CO ₂ or equivalent
ISO14175: M21	75-80% Ar, Bal. CO ₂

FINISHING RECOMMENDATIONS:

Machinable. Carbide tools recommended.

DOWNHAND & HORIZONTAL BUILD-UP APPLICATIONS:

1.2mm and 1.6mm sizes can be used for vertical surfacing by depositing overlapping horizontal stringer passes.



PACKAGING & OPERATING DATA:

DC Positive

WIRE DIAMETER (MM)	CURRENT RANGE AMPS	VOLTAGE RANGE VOLTS	ELECTRODE STICK-OUT (ESO) MM	PACK TYPE	PACK WEIGHT	PART NUMBER
1.2	120-220	18-24	15-20	Spool	15kg	728260
1.6	140-250	23-26	15-25	Spool	15kg	728261