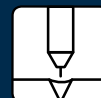


## COBALARC 650-FC

### PRODUCT DATA SHEET



### GAS SHIELDED TUBULAR HARDFACING WIRE



### COBALARC & STODY HARDFACING CONSUMABLES

#### COBALARC 650-FC

- Gas (-G) Tubular Hardfacing Wires
- Air Hardening, Crack Free, Martensitic Steel Deposit.
- Resistant to Hard Particle Abrasion and Moderate Impact Loading
- Can be used for vertical surfacing by depositing overlapping horizontal stringer passes.
- Typical applications include the surfacing of agricultural points, shears and tines, sand dredge cutter heads, dredge rollers and tumblers, conveyor screws, bucket lips, etc.
- Precision layer wound on 4.5kg & 15kg spools

#### CLASSIFICATIONS:

ISO AS/NZS: 2576	1855-B5
W.T.I.A. Tech Note 4:	1855-B5

#### TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C:	0.60%
Mn:	1.70%
Si:	0.40%
Cr:	6.20%
Fe:	Balance

#### TYPICAL WELD DEPOSIT HARDNESS:

	HR <sub>c</sub>	HV <sub>30</sub>
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	58	640

DESCRIPTION AND APPLICATIONS:

Cobalarc 650-FC is a tubular hard surfacing wire for surfacing components subjected to wet or dry hard particle abrasion and low to moderate impact loading. The air hardening martensitic steel weld deposit of Cobalarc 650-FC remains crack free on most steels under normal welding conditions and is therefore recommended for the surfacing of components subject to flexing during service.

Typical applications include the surfacing of agricultural points, shears and tines, sand dredge cutter heads, dredge rollers and tumblers, conveyor screws, bucket lips, etc.

COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650 extruded electrode  
AS/NZS 2576: 1855-A4

RECOMMENDED SHIELDING GASES:

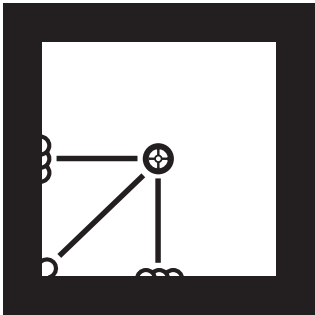
ISO14175: M13	Ar+ 1-3% O2 or equivalent
ISO14175: M21	75-80% Ar, Bal. CO2

FINISHING RECOMMENDATIONS:

Not Machinable. Grinding only.

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 Negative

WIRE DIAMETER (MM)	CURRENT RANGE AMPS	VOLTAGE RANGE VOLTS	ELECTRODE STICK-OUT (ESO) MM	PACK TYPE	PACK WEIGHT	PART NUMBER
1.2	120-220	18-28	15-20	D200 Spool	4.5kg	724258
1.2	120-220	18-28	15-20	D300 Spool	15kg	724262
1.6	140-250	23-29	20-25	D300 Spool	15kg	724263