

## COBALARC 650

**HV<sub>30</sub>**  
**425**
**55**  
**OCV**
**AC**  
**DC+**

- Basic Type Manual Arc Welding Electrode.
- Resistant to Hard Particle Abrasion and Moderate Impact Loading.
- Air Hardening, Crack Free, Martensitic Steel Deposit- 640 HV<sub>30</sub>
- Packed in Resealable Plastic Tubes

### Classifications:

ISO AS/NZS 2576: 1855-A4  
 EN ISO 14700: E Z Fe3

### Description and Applications:

Cobalarc 650 is a basic electrode for the hard surfacing of steel components subjected to wet or dry hard particle abrasion and low to moderate impact loading.

The air hardening, low alloy steel deposit of Cobalarc 650 remains crack free on most steels under normal welding conditions and is therefore recommended for hard surfacing components subject to flexing during service.

The basic flux coating gives excellent resistance to rust, mill scale, dirt and oil on the surface being hardfaced.

Typical applications include the surfacing of agricultural points, shares and tynes, grader and dozer blades, conveyor screws and post hole augers etc.

### TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C: 0.58% Mn: 1.1% Si: 0.6%  
 Cr: 5.3% Mo: 0.25%

### TYPICAL WELD DEPOSIT HARDNESS:

	HR <sub>C</sub>	HV <sub>30</sub>
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	57	640

### FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

### COMPARABLE CIGWELD PRODUCTS:

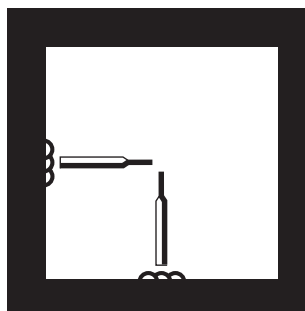
Stoody 965 G/O tubular wire

Stoody 965-AP

AS/NZS 2576: 1855-B5/B7

Stoody 850-O tubular wire

AS/NZS 2576: 1865-B7



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

### Packaging and Operating Data:

AC (minimum 55 O.C.V.), DC+ polarity.

Electrode Size mm	Length mm	No. of Electrodes per kg	Current Range (amps)	Packet	Carton	Part No
3.2	450	24	100-130	5.3kg	15.9kg - 3 x 5.3kg	611463N
4.0	450	16	130-180	5.2kg	15.6kg - 3 x 5.2kg	611464N