

## COBALARC 750

### PRODUCT DATA SHEET



### RUTILE TYPE, AC/DC HARD SURFACING ELECTRODE

HV<sub>30</sub>  
720

45  
OCV

AC  
DC+

### COBALARC & STOODY HARDFACING CONSUMABLES

#### COBALARC 750

- Rutile type, AC/DC Hard Surfacing Electrode.
- Resistant to Hard Particle Abrasion.
- Air Hardening, Crack Free, Martensitic Steel Deposit - 750 HV<sub>30</sub>
- Easy Arc Starting and Stable Running on Portable AC Welding Sets ( ≥ 45 O.C.V. ).

#### CLASSIFICATIONS:

ISO AS/NZS: 2576	1860-A4
W.T.I.A. Tech Note 4:	1860-A4

#### TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

C:	0.60%
Mn:	0.46%
Si:	0.75%
Cr:	5.9%
Mo:	0.40%

#### TYPICAL WELD DEPOSIT HARDNESS:

	HR <sub>c</sub>	HV <sub>30</sub>
Single Layer on Mild Steel	64	800
Two Layers on Mild Steel*	62	750

\*Not recommended for multi-pass welding heavier than 3 layers.

## DESCRIPTION AND APPLICATIONS:

Cobalarc 750 is a smooth running, rutile type electrode specifically designed for AC hard surfacing applications in the workshop or on the land.

It gives smooth stable arcing on AC or DC welding machines and is particularly suitable for surfacing with portable AC welding sets (with  $\geq 45$  Open Circuit Volts) such as the CIGWELD Easywelder.

Cobalarc 750 should be used with a touch welding or short arc technique and 1-2 layers are recommended for maximum deposit hardness.

When hard surfacing high carbon or low alloy steel components a buffer or buttering layer of Ferrocrafter 16TXP or Ferrocrafter 7016 is recommended prior to depositing Cobalarc 750.

Typical applications include the surfacing of agricultural equipment and components including points, shares, post hole augers, ripper teeth and tynes etc.

## COMPARABLE CIGWELD PRODUCTS:

Cobalarc 650 manual arc electrode  
AS/NZS 2576: 1855-A4  
Stoody 965-G/O tubular wire  
AS/NZS 2576: 1855-B5/B7  
Stoody 850-O tubular wire  
AS/NZS 2576: 1865-B7

## PACKAGING & OPERATING DATA:

AC (minimum 45 O.C.V.), DC+ polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACKET	CARTON	PART NO.
3.2	350	26	95-130	5kg	15kg / 3 x 5kg	611473
4.0	350	17	120-170	5kg	15kg / 3 x 5kg	611474

## FINISHING RECOMMENDATIONS:

Not Machinable / Grinding only.

## DOWNHAND & HORIZONTAL HARD SURFACING APPLICATIONS:

3.2mm and 4.0mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.

