CIGWELD

AN ESAB BRAND

FCAW

COBALARC COARSECLAD-FC

PRODUCT DATA SHEET

HIGH ALLOY, TUBULAR HARDFACING WIRE

DC +

COBALARC & STOODY HARDFACING CONSUMABLES

COBALARC COARSECLAD-FC

- High Alloy, Tubular Hardfacing Wire
- High Chromium - Carbide Iron Deposit. For Ground Engaging Applications.
- Resistant to Severe Abrasion and Low to Moderate Impact Loading.
- Typical applications include the hard surfacing of crusher cones and mantles, swing hammers, earthmoving buckets, scarifier points and sugar harvesting and milling equipment.

CLASSIFICATIONS:

	1.6mm*
ISO AS/NZS: 2576	**2360-B7**
W.T.I.A. Tech Note 4:	**2360-B7**

*1.6mm is a B7 type wire which requires no shielding gas

TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

Single Layer Mild Steel	
C:	**4.0%**
Mn:	**0.7%**
Si:	**0.7%**
Cr:	**14.0%**
All Weld Metal Deposit	
C:	**4.0%**
Mn:	**0.7%**
Si:	**0.7%**
Cr:	**19.0%**

TYPICAL WELD DEPOSIT HARDNESS:

	HR_C	HV_{30}
Single Layer on Mild Steel	**55**	**600**
All Weld Metal Deposit	**60**	**700**

Deposits contain Chromium Carbides with hardness up to 1,500 HV (80 HRc).

DESCRIPTION AND APPLICATIONS:

Cobalarc Coarseclad-FC is a high alloy tubular hardfacing wire depositing a high chromium carbide iron particularly resistant to severe coarse (large particle) abrasion. The weld deposit of Cobalarc Coarseclad-FC produces a high level of primary chromium carbides resistant to coarse abrasion (in particular gouging abrasion) at temperatures up to 650°C.

Weld deposits can be finished by grinding and relief checking is normal. Typical applications of Cobalarc Coarseclad-FC include the hard surfacing of crusher cones and mantles, swing hammers, earthmoving buckets, scarifier points and sugar harvesting and milling equipment. For high impact applications Cobalarc Coarseclad-FC deposits should be restricted to one layer.

COMPARABLE CIGWELD PRODUCTS:

Cobalarc CR70 extruded electrode AS/NZS 2576: 2355-A4

WELD DEPOSIT MICROSTRUCTURE:

Two layers of Cobalarc Coarseclad-FC onto a mild steel component will produce approximately 25 - 30% primary chromium iron carbides in a carbide-ferrite matrix ideal for severe abrasion and low to moderate impact applications.

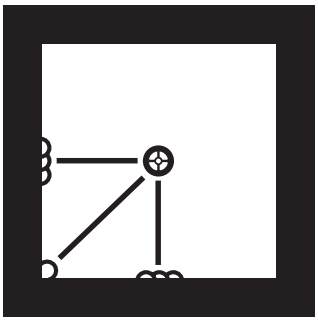
RECOMMENDED SHIELDING GASES:

ISO14175: C1	Open Arc or welding grade CO_2

FINISHING RECOMMENDATIONS:

Grinding only.

FOR DOWNHAND & HORIZONTAL SURFACING APPLICATIONS



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
1.6	200-260	24-28	15-25	Spool	15kg	728054