

COBALARC CR70

PRODUCT DATA SHEET



HIGHLY ALLOYED MANUAL ARC ELECTRODE

HV₃₀
650

50
OCV

AC
DC+

COBALARC & STOODY HARDFACING CONSUMABLES

COBALARC CR70

- Highly Alloyed Manual Arc Electrode.
 - High Chromium Carbide Iron Deposit.
 - Primary Chromium Iron Carbides in a Single Layer.
 - Ideal for Coarse Abrasion and Low to Moderate Impact Loading.
 - Typical applications of Cobalarc CR70 include the hard surfacing of crusher cones and mantles, swing hammers, bucket teeth and lips, dozer end plates and sugar mill rolls etc.
- 4.0mm size can be used for vertical welding by depositing overlapping horizontal stringer passes.

CLASSIFICATIONS:

ISO AS/NZS 2576:	2355-A4
W.T.I.A. Tech Note 4:	2355-A4

TYPICAL ALL WELD METAL DEPOSIT ANALYSIS:

Single Layer on Mild Steel:

C:	3.3%
Mn:	1.5%
Si:	1.0%
Cr:	25%

All Weld Metal Deposit:

C:	4.0%
Mn:	1.8%
Si:	1.2%
Cr:	31%

DESCRIPTION AND APPLICATIONS:

Cobalarc CR70 is a popular high alloy extruded hard surfacing electrode manufactured by CIGWELD. The weld deposit of Cobalarc CR70 produces a high level of primary chromium carbides resistant to coarse abrasion (in particular gouging abrasion) and moderate impact loading at temperatures up to $\approx 650^{\circ}\text{C}$.

Weld deposits can be finished by grinding and are best limited to two layers because of relief checking.

Typical applications of Cobalarc CR70 include the hard surfacing of crusher cones and mantles, swing hammers, bucket teeth and lips, dozer end plates and sugar mill rolls etc.

COMPARABLE CIGWELD PRODUCTS:

Stoody 100 HC-G/O tubular wire
AS/NZS 2576: 2360-B5/B7

TYPICAL WELD DEPOSIT HARDNESS:

	HR _C :	HV ₃₀ :
Single Layer on Mild Steel	55	600
All Weld Metal Deposit	58	690

Deposits contain Chromium Carbides with hardness up to 1,500 HV.

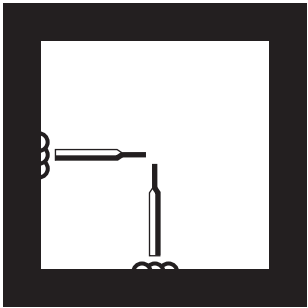
FINISHING RECOMMENDATIONS:

Grinding only.

WELDING POSITIONS:

Downhand and Horizontal joining and build-up applications:

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



PACKAGING AND OPERATING DATA:

AC (minimum 50 O.C.V.), DC+ polarity.

ELECTRODE SIZE (MM)	ELECTRODE LENGTH (MM)	APPROX NO. RODS/KG	CURRENT RANGE (AMPS)	PACKET	CARTON	PART NO.
4.0	350	11	130-200	5kg	15kg / 3 x 5kg	613494
5.0	450	6	180-250	5kg	15kg / 3 x 5kg	613495

