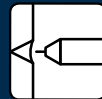


COBALARC 650-FC

PRODUCT DATA SHEET



GAS SHIELDED TUBULAR HARDFACING WIRE



COBALARC & STOODY 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, shares and tynes, sand dredge cutter heads, dredge rollers and tumblers, conveyor screws, bucket lips, etc

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 _C	HV ₃₀
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, shares and tynes, 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

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	18-24	15-20	D200 Spool	4.5kg	724258
1.2	120-220	18-24	15-20	D300 Spool	15kg	724262
1.6	140-250	23-26	20-25	D300 Spool	15kg	724263

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.

