

# Cobalarc Hardfacing Electrodes

## Cobalarc CR70

HV<sub>30</sub>  
590

50  
ocv

AC  
DC



- 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.

NOTE: 3.2mm and 4.00mm sizes can be used for vertical welding by depositing overlapping horizontal stringer passes.

### Classifications:

AS/NZS 2756:	2355-A4
WTIA Tech. Note 4:	2355-A4

### Typical Weld 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%

### Typical Weld Deposit Hardness:

	HRC	HV <sub>30</sub>
Single layer on mild steel	55	600
All weld metal deposit	59	690

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

### Finishing Recommendations:

Grinding only

### Comparable CIGWELD products:

Stoody 101 HC-G/O tubular wire  
AS/NZS 2576: 2360-B5/B7

### Packaging and Operating Data:

Electrode		Approx No.	Current	Packet	Carton	Part No
Size mm	Length mm	Rods/kg	Range (amps)			
3.2	380	18	90 – 140	5kg	15kg - 3 x 5kg	613493
4.0	380	11	130 – 200	5kg	15kg - 3 x 5kg	613494
5.0	450	6	180 – 250	5kg	15kg - 3 x 5kg	613495

AC (minimum 50 OCV) DC+ or DC- polarity.

## Cobalarc BoroChrome

HV<sub>30</sub>  
700

50  
ocv

AC  
DC



- Highly Alloyed Manual Arc Electrode.
- Martensitic Chromium Carbide Iron Deposit.
- Ideal for Fine Particle (Wet or Dry) Abrasion and Low Impact Loading.
- Primary Chromium Iron Carbides in a Hard, Martensitic Matrix.
- Typical applications include the hard surfacing of sand chutes, dredge components, ripper shanks, screens, grizzly bars, scraper blades and bucket lips and teeth.

### Classifications:

AS/NZS 2756:	2560-A4
WTIA Tech. Note 4:	2560-A4

### Typical Weld Deposit Analysis:

Single Layer on Mild Steel  
C: 2.7% Mn: 0.4% Si: 1.8%  
Cr: 20.0% V: 1.4% B: 1.0%  
All Weld Metal Deposit  
C: 3.2% Mn: 0.4% Si: 2.4%  
Cr: 24.0% V: 1.7% B: 1.2%

### Typical Weld Deposit Hardness:

	HRC	HV <sub>30</sub>
Single layer on mild steel	58	660
All weld metal deposit	60	700

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

### Finishing Recommendations:

Grinding only

### Comparable CIGWELD products:

Stoody Fineclad-O tubular wire  
AS/NZS 2576: 2565-B7

### Packaging and Operating Data:

Electrode		Approx No.	Current	Packet	Carton	Part No
Size mm	Length mm	Rods/kg	Range (amps)			
4.0	380	11	140 – 180	5kg	15kg - 3 x 5kg	613964
5.0	450	6	170 – 210	5kg	15kg - 3 x 5kg	613965

AC (minimum 50 OCV) DC+ or DC- polarity.