

# Cobalarc 9e

HV<sub>30</sub>  
750

55  
OCV

AC  
DC+



- Highly Alloyed Extruded Electrode.
- Versatile, Complex Carbide Iron Deposit.
- Resistant to both Coarse and Fine Abrasion and Moderate to Heavy Impact Loading.
- Typical applications include the hard surfacing of railway ballast tampers, dredge buckets and lips, earth moving equipment, power shovels, rolling mill guides, sizing screens, ripper teeth and crushing equipment.

## Classifications:

AS/NZS 2756: 2460-A4  
 WTIA Tech. Note 4: 2460-A4

**Typical All Weld Deposit Analysis:**  
 C: 4.8% Mn: 1.1% Si: 1.4%  
 Cr: 30.0% Ni: 0.5% Mo: 1.7% V: 0.2%

**Finishing Recommendations:**  
 Grinding only

**Typical Weld Deposit Hardness:**

	HRC	HV30
Single layer on mild steel	58	660
All weld metal deposit	63	780

**Comparable CIGWELD products:**  
 Stoodly 143-0

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

## Packaging and Operating Data:

Electrode Size mm	Length mm	Approx No. Rods/kg	Current Range (amps)	Packet	Carton	Part No
3.2	380	17	95 – 145	5kg	15kg - 3 x 5 kg	613350
4.0	380	10	130 – 190	5kg	15kg - 3 x 5kg	613360
5.0	450	5	170 – 260	5kg	15kg - 3 x 5kg	613370

AC (minimum 55 OCV) DC+ or DC- polarity.

