



MAC HICA E3071

■ **Description & Applications:**

Cobalt based electrode designed on a fully alloyed core wire to combat all four elements of wear, i.e. heat, impact, corrosion and abrasion. Most suitable of cobalt range where abrasion is the most predominant of the four elements of wear. Excellent for rebuilding corners with minimum base metal dilution. Has ability to overlay extensive areas without cracking. Will retain hardness at high temperatures. Welds are non-machinable. Recommended for use in the iron and steel industries or any industry where heat, corrosion and abrasion occur concurrently.

■ **Related Specification:**

AWS E Co-CR-C

■ **Typical All Weld Metal Chemical Analysis %:**

C	Cr	W	Fe	Co
2.5	30.0	12.0	3.0	Balance

■ **Typical All Weld Deposit Hardness:**

	HRC	HV
+20°C	56	600
+400°C	48	480
+800°C	26	270

■ **Current:**

AC/DC (+).

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm
70-90	90-115	100-150	170-220

Recommended Welding Positions

1G & 3G

■ **Storage:**

If allowed to become damp the electrodes should be re-dried for one hour at 150° C before use.