



Mac Hica E3072

■ **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. High impact properties. Most suitable of cobalt range where impact 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. The welds are machinable. Recommended for use in iron and steel industries. Suitable for use on shear blades, dies, punches and all applications where good resistance to heat, impact, corrosion and abrasion is required.

■ **Related Specification:**

AWS E-Co-Cr-A

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

C	Cr	Fe	W	Co
1.0	31.0	2.0	5.5	Balance

■ **Current:**

AC/DC (+). DC positive

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.40mm
60-75	90-115	100-150	150-220	220-275

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.