



MAC HICA E3073

■ **Description & Applications:**

Cobalt based electrode made on a fully alloyed core wire designed to combat all four elements of wear, i.e. heat, impact, corrosion and abrasion. The electrode provides optimum impact and abrasion resistant properties while retaining hardness at elevated temperatures. 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. Suitable for use in industries where severe impact and abrasion occurs.

■ **Related Specification:**

AWS E Co Cr-B

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

C	Cr	W	Fe	Co
1.9	30.0	8.4	3.0	BAL

■ **Typical All Weld Deposit Hardness:**

	<u>HRC</u>	<u>HV</u>
+ 20°C	51	546
+ 200°C	42	418
+ 400°C	39	380
+ 600°C	37	362

■ **Current:**

AC/DC (+)

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm	5.00mm	6.40mm
60-75	90-115	100-150	170-220	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.