



MAC HICA E3076

■ **Description & Applications:**

Cobalt based electrode designed on a fully alloyed core wire. It is resistant to wear, galling and corrosion, retaining these properties at high temperatures. This electrode has exceptional fatigue resistance. Useful for tools working hot steel. Also resistant to thermal cracking, hot metal on metal wear, and surface fatigue. The welds are machinable. Recommended for use in iron and steel industries. Suitable for use on piercing points, forming tools, extrusion dies, and furnace hardware, and all applications where a combination of metal-on-metal wear, thermal fatigue and hot corrosion resistance is required.

■ **Related Specification:**

Cobalt Special

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

C	Mn	Si	Cr	Ni	Fe	W	S	Co
0.1	1.5	0.4	20.0	10.0	2.0	15.0	0.02	Balance

■ **Current:**

AC/DC (+). DC positive

■ **Sizes Available and Recommended Amperages:**

2.50mm	3.25mm	4.00mm
60-75	90-115	100-150

■ **Storage:**

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