

Kobatek 600B

TOP FEATURES

- The highest abrasion resistance is obtained in 3-pass welding applications
- The finely adjusted "Cr" content enables the filler metal to resist non-intense corrosive effects
- It retains its hardness at operating temperatures up to 500 °C
- Weld metal can be machined by grinding and the risk of cracks and pores in the weld seam is very low.

TYPICAL APPLICATIONS

- Drilling bits
- Scraper blades of earth-moving machines
- Bucket edges and bucket teeth
- Mixer blades
- Excavator parts
- Guillotine shears
- Cold work tool steel cutting edges
- Pump screws used in cement industry
- Conveyor screws
- Crusher hammers
- Crusher jaws and cones
- Coal planes
- Polygon edges
- Die casting molds
- Rollers



CURRENT TYPE

DC(+); AC min 65 V

MECHANICAL PROPERTIES, ALL WELD METAL

Hardness
(HRC)

54-58

Hardening: Cooling in oil or air at 950-1000 °C
Annealing: Slow cooling in oven at 850 °C

OUTPUT RANGE

Diameter x Length (mm)	Current range (A)
3.2 x 350	110-140
4.0 x 450	150-190
5.0 x 450	180-240

PACKAGING AND AVAILABLE SIZES

Diameter (mm)	Packaging	Net weight/pack (kg)	Item number
3.2 x 350	PE Tube	5.0	784600B32
4.0 x 450	PE Tube	5.0	784600B40
5.0 x 450	PE Tube	5.0	784600B50

TEST RESULTS

Test results for mechanical properties, deposit or electrode composition and diffusible hydrogen levels were obtained from a weld produced and tested according to prescribed standards, and should not be assumed to be the expected results in a particular application or weldment. Actual results will vary depending on many factors, including, but not limited to, weld procedure, plate chemistry and temperature, weldment design and fabrication methods. Users are cautioned to confirm by qualification testing, or other appropriate means, the suitability of any welding consumable and procedure before use in the intended application

Safety Data Sheets (SDS) are available here:



Subject to Change – The information is accurate to the best of our knowledge at the time of printing.
Please refer to www.lincolnelectric.eu for any updated information.