



AC/DC+

HARDFACING

DESCRIPTION

Cost-efficient high-recovery chromium carbide electrode for hardfacing carbon steel, low alloy steel and manganese steel parts subjected to **severe abrasion** and **moderate impacts**.

CHARACTERISTICS

- **Excellent high compressive stress resistance**
- Crack-resistant and forgeable deposit
- Smooth arc and low spatter
- Dense deposit
- Easy slag removal

Deposit rating scale

ABRASION										
IMPACT										
HEAT										
COMPRESSION										
	1	2	3	4	5	6	7	8	9	10

Hardness (as-welded): 38 – 42 HRC Work hardening: 50 – 55 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Construction and farm equipment, bulldozer pads, rollers, lift ram mechanical systems, crusher jaws and rolls, gear teeth, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12** electrode. Maintain a medium arc with the electrode slightly tilted. Remove slag between each pass. If more than two passes are required, use **Soudotec 340** or **Soudotec 342** as a cushion.

WELDING PARAMETERS

Diameter: 5.0 mm (3/16") 4.0 mm (5/32") 3.2 mm (1/8")
 Amperage: 180 - 220 A 140 - 160 A 110 - 125 A

Flux-cored wire also available: **Soudotec FC 8332** (wire slightly more alloyed than the electrode)

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Specialized welding alloys and technology. For technical assistance or for ordering:



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