



AC/DC+

**HARDFACING**

**DESCRIPTION**

Tubular electrode with Ni-Cr-B-Si matrix and a high percentage of **tungsten carbides** for hardfacing mild steel, low-alloy steel and medium carbon content steel parts subjected to **extreme abrasion with no violent impacts**. Excellent resistance to acids and other corrosive agents.

**CHARACTERISTICS**

- 65% tungsten carbide content
- Low heat input due to very low amperage
- All position application
- Dense, smooth, porosity-free and slag-free deposits
- Good resistance to heat
- Grindable deposit only (diamond grinder)

Deposit rating scale

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

Hardness (matrix): 54 - 56 HRC  
 Deposit thickness: 2 passes maximum  
 Tungsten carbides: 2360 HV (Vickers)

**TYPICAL APPLICATIONS**

Drilling tools hardfacing and varied parts used in chemical industries, food industries, pulp and paper, aluminum industries, mines, foundries, brickworks, etc.

**PROCEDURE**

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with **Soudotec 212 SP** or **Soudotec G12** electrode. Preheating is recommended for heavy parts. Set the intensity of the current to minimum levels to avoid the fusion of tungsten carbides. Maintain a medium arc with the electrode slightly tilted and with a slight weaving movement. If more than two (2) passes are required, use the **Soudotec 206** electrode as a cushion. Let cool down slowly.

**WELDING PARAMETERS**

Diameter: 5.0 mm (3/16") 4.0 mm (5/32")  
 Amperage: 110 - 130 A 90 - 110 A

Also available in tubular rods: **Soudotec 396** and in metal-cored wire: **Soudotec MC 8399G**

Rév.: 7\_01

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



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