

DESCRIPTION

Open arc multi-pass flux-cored wire with a **high chromium carbide** deposit for hardfacing on carbon, manganese and stainless steels, subjected to **severe abrasion** with **moderate impacts**.

CHARACTERISTICS

- Retain good hardness at high temperature
- No shielded gas required
- Good high temperature and corrosion resistance (up to 480°C / 896°F)
- Grindable deposit only
- Smooth and dense deposit
- High deposit rate

Deposit rating scale

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

Hardness (as-welded): 52 HRC
 Deposit thickness: 3 - 5 passes maximum

TYPICAL APPLICATIONS

Crusher rollers, jaws and cones, bucket teeth, conveyor screws, mixer blades, concrete pumps, 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. Use **Soudotec FC 8340** as a cushion before hardfacing. When using a constant current power supply (generator), it is preferable to use a shielded gas (100% CO₂ or 75 % Ar - 25 % CO₂) to improve the arc stability. When shielded gas is used, reduce the stick-out.

WELDING PARAMETERS

Diameter: 1/16" (1.6 mm) .045" (1.2 mm)
 Voltage: 20 - 28 V 15 - 26 V
 Amperage: 160 - 300 A 100 - 250 A
 Stick-out: 1" - 1½" 3/4" - 1"
 Packaging: Spool : 1.2 mm - 1.6 mm

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



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