

**DESCRIPTION**

Open arc flux-cored wire for **building up and overlaying** before hardfacing on high alloy steels, manganese steels and difficult-to-weld steels. High resistance to **severe impacts, moderate abrasion, heat and corrosion.**

**CHARACTERISTICS**

- Crack-resistant and work hardening deposit
- No shielded gas required
- Corrosion and high temperature resistance (up to 800°C/1472°F)
- Smooth, dense and porosity-free deposit
- High deposit rate

Deposit rating scale

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

Hardness (as-welded): 225 BH (Work hardening deposit)  
 Deposit thickness: Unlimited

**TYPICAL APPLICATIONS**

Wear plates, rail wheels, equipment use in mining industries, construction, excavation, pulp and paper, 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. When using a constant current power supply (generator), it is preferable to use a shielded gas (75 % Ar – 25 % CO<sub>2</sub>) to improve the arc stability.

**WELDING PARAMETERS**

Diameter:	7/64" (2.8 mm)	3/32" (2.5 mm)	1/16" (1.6 mm)	.045" (1.2mm)
Voltage:	28 - 30 V	27 - 29 V	26 - 28 V	24 - 26 V
Amperage:	325 - 375 A	280 - 340 A	170 - 260 A	150 - 200 A
Stick-out:	2" - 3"	2" - 3"	1½" - 2½"	1" - 2"
Packaging:	Spool : 1.2 mm, 1.6 mm ; Coil : 1.6 mm, 2.5 mm, 2.8 mm ; Drum on request			

Rev. : 7\_01

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



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