

 **Soudotec MC 8399G** DC+

**HARDFACING**

**DESCRIPTION**

Gas shielded metal-cored Ni-Cr-B-Si wire (MCAW) **without slag**, with a **high content of tungsten carbide** particles for hardfacing on carbon or low alloy steel, austenitic and ferritic steel, subjected to **extreme abrasion, acids and other corrosive agents**.

**CHARACTERISTICS**

- **Very fast process to apply tungsten carbides**
- Low spatter
- Grindable deposit only (diamond grinder)
- All-position welding
- Heat resistance up to 450°C (842°F)

Deposit rating scale

<b>ABRASION</b>										
<b>IMPACT</b>										
<b>HEAT</b>										
<b>CORROSION</b>										
	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 the **Soudotec 212 SP** or **Soudotec G12** electrode.

**WELDING PARAMETERS**

Gas: 75 % Ar - 25 % CO<sub>2</sub> or 99 % Ar – 1 % O<sub>2</sub>  
 Diameter: 1/16" (1.6 mm)  
 Voltage: 24 - 26 V  
 Amperage: 180 - 220 A  
 Stick-out: 1" - 1½"  
 Packaging: Spool of 5 kg and 15 kg: 1.6 mm

Also available in tubular rods: **Soudotec 396** and tubular electrodes: **Soudotec 399**

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



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