FILLER METAL SELECTION TABLE FOR BUILD UP AND HARDFACING

PRODUCTS	Hardness (as-welded) (HRC)	Deposit thickness (number of passes)	Slag free	High-recovery (coated electrodes)	Contact electrodes	Can be used for assemblies	Hardfacing	Build up and cushion before hardfacing	Work hardening deposit	Machinable deposits	Available in flux-cored wire (.045 (1.2mm)	Low amperage tubular electrode	All-position	Cobalt base alloys	Chromium carbide base alloys	Tungsten carbide base alloys	TIG or torch	Coated electrode and/or flux-cored wire
M600	57	3	✓				✓											
M300	32	Unlimited	✓					✓		✓			✓					
8306G	42-45	2	✓				✓						✓	✓				
81XX - 8399G	54-56 +WC	2					✓									✓	✓	✓
8377	225 (BH)	Unlimited				✓		✓	✓	✓								✓
399	54-56 +WC	2					✓					✓	✓			✓		✓
398 - 8398G	60-63 +WC	2	✓				✓					✓	✓			✓		✓
397	58-60 +WC	2					✓									✓	✓	
390	55-60	3			✓		✓						✓		✓			✓
359	58-62	2					✓										✓	
346	58-62	2	✓	✓			✓					✓	✓		✓			✓
345S - 345	62	2			✓		✓						✓					✓
344	42-45	5			✓		✓			✓			✓		✓			✓
8340 - 342	250 (BH)	Unlimited		✓	✓	✓		✓	✓	✓	✓							✓
8342 (W) - *340	170-395 (BH)	Unlimited				*✓		✓	✓	✓	✓		✓					✓
336	62-64	2	✓	✓			✓								✓			✓
333 SP	65-67	2	✓	✓			✓								✓			✓
8333 - 333	62-65	2	✓	✓			✓								✓			✓
8332 (W) - 332	38-60	2		✓	✓		✓		✓		✓				✓			✓
330- 8330-*8330 SP	58-63 *52	2 *3-5		✓	✓		✓				✓				✓			✓
329	200 BH +WC	3					✓										✓	✓ Tor
C06 - 6G	40-45	2			✓		✓			✓			✓	✓			✓ 6G	✓ C06
C01 - 1G	53-57	2			✓		✓						✓	✓			✓ 1G	✓ C01

✓ = Recommended product(s)

NOTE: Electrode hardness values may vary depending on the hardness value of the flux cored wire used. For more information, consult the Technical Data Sheet for the specific product.

This table is not exhaustive; other products may be suitable for certain applications and/or characteristics. Consult the **FSH Welding Canada** Technical Department.

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