



330 AC/DC+

HARDFACING

DESCRIPTION

High-recovery (160%) electrode with **high chromium carbide** for hardfacing mild steel, low alloy steel, stainless steel and manganese steel parts subjected to **severe abrasion** and **moderate impacts**.

CHARACTERISTICS

- **Corrosion and high temperature resistance**
- Smooth and dense deposit
- Smooth and stable arc, spatter free
- Easy slag removal
- Very high deposit rate
- Minimum dilution rate for superior hardness, even at elevated temperatures
- Grindable deposits only

Deposit rating scale

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

Hardness (as-welded): 58 – 63 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Bucket lips/teeth, conveyors, scrapers, crusher material, rollers, hammers, augers, press screws, excavation equipment, 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. Maintain a medium arc with the electrode slightly tilted. Remove slag between each pass. If more than two (2) passes are required, use the **Soudotec 340** or **Soudotec 342** electrode as a cushion.

WELDING PARAMETERS

Diameter: 6.3 mm (1/4") 5.0 mm (3/16") 4.0 mm (5/32") 3.2 mm (1/8") 2.5mm (3/32")
 Amperage: 240 - 320 A 210 - 270 A 160 - 190 A 110 - 140 A 80 - 100 A

Flux-cored wire also available: **Soudotec FC 8330**

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



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