

333 AC/DC+

HARDFACING

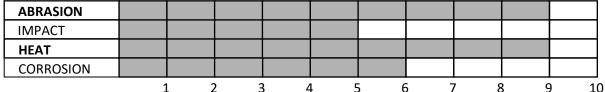
DESCRIPTION

High-recovery (190%) slag-free electrode with complex chromium and niobium carbides for hardfacing mild steel, low alloy steel, stainless steel and manganese steel parts subjected to **severe abrasion**, **heat** and **moderate impacts**.

CHARACTERISTICS

- Heat and corrosion resistance, up to 450°C (842°F)
- Slag-free deposit
- Smooth and regular fusion
- Chromium and niobium carbide alloys
- High deposit rate

Deposit rating scale



Hardness (as-welded): 63 - 65 HRC
Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Mixer blades, refractory press screws, plow blades, scrapers, bucket teeth, gate valves, ore crushers, wear plates, 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. If more than two passes are required, use **Soudotec 340** or **Soudotec 206** as a cushion.

WELDING PARAMETERS

Diameter: 5.0 mm (3/16") 4.0 mm (5/32") 3.2 mm (1/8") Amperage: 190 - 260 A 140 - 190 A 120 - 150 A

Rev.: 21_08

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



info@fsh-welding.ca www.fsh-welding.ca 2204, 46° avenue Lachine (Mtl),Québec Canada H8T 2P3

Tél: 514.631.7670 1.800.361.9097