



336 AC/DC+

HARDFACING

DESCRIPTION

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

CHARACTERISTICS

- Smooth arc and spatter-free
- Corrosion and heat resistant
- Smooth and dense deposit
- Slag-free and basic coating
- Very high deposition rate
- Minimum dilution rate for superior hardness, even at elevated temperatures
- Grindable deposits only

Deposit rating scale

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

Hardness (as-welded): 62 – 64 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Pumps, valves, augers, turbines, conveyors, bucket teeth, crusher rolls, excavation equipment, plow blades, hammers, 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 342** as a cushion.

WELDING PARAMETERS

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	190 - 210 A	180 - 220 A	120 - 160 A

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



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