

344 AC/DC+

HARDFACING

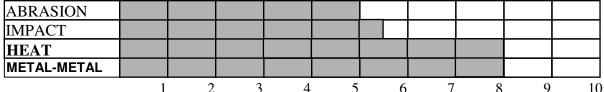
DESCRIPTION

All-position hardfacing electrode containing fine carbides of tungsten, chromium and vanadium, for hardfacing carbon steel, low-alloy steel, cast steel and manganese steel parts subjected to abrasion, moderate impact, and metal-to-metal friction up to 550°C (1022°F).

CHARACTERISTICS

- Excellent all-position weldability, even on AC power supply
- Crack-free deposit
- Smooth arc and spatter-free
- Dense, machinable and porosity-free deposits
- Easy slag removal

Deposit rating scale



Hardness (as-welded): 42 - 45 HRC Deposit thickness: 5 passes maximum

TYPICAL APPLICATIONS

Scrap cutting shears, trimming and blanking dies, shear blades; forging dies, cold and hot working dies, hammer dies, etc.

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Remove damaged metal with **Soudotec 212 SP** or **Soudotec G12**. Keep a short arc with the electrode slightly inclined. Remove slag between passes. Cool slowly. Depending of the base metal a preheating can be necessary.

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8") Amperage: 150 - 170 A 105 - 125 A

Rev.: 21_08

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



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