



359

HARDFACING

DESCRIPTION

Bare **nickel-chrome-bore** rod for hardfacing mild steel, low-alloy steel, stainless steel and cast iron parts subjected to **high temperatures** and/or **corrosion** combined with **abrasion**, **erosion**, **metal-to-metal frictional wear** and/or **moderate impacts**.

CHARACTERISTICS

- Maintains excellent hardness at high temperatures
- Can be used with a torch or TIG
- Smooth, shiny and porosity-free deposits
- Can be used without flux
- Instantaneous first-pass hardness

Deposit rating scale

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

Hardness (as-welded): 58 - 62 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Flour mixer blades, conveyor screws, cams, pump shafts, valves, debarking tools, etc.

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Remove damaged metal with **Soudotec** or **Soudotec G12**. Grind and smooth down rugged corners. Heat with a torch until metal turns dark then start applying **Soudotec 359**. Avoid overheating the base metal. Cool slowly.

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8")
 Bonding temperature: 980°C (1800°F)
 Type of flame: Neutral

Rév.: 21_08

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



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