



390 AC/DC+

HARDFACING

DESCRIPTION

All-position **economical hardfacing** electrode for hardfacing carbon steels, low-alloy steels, cast steels and manganese steels subjected to **abrasion, moderate impacts, and metal-to-metal friction.**

CHARACTERISTICS

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

Deposit rating scale

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

Hardness (as-welded): 55 - 60 HRC
 Deposit thickness: 3 passes maximum

TYPICAL APPLICATIONS

Crusher jaws, plow blades, excavation equipment, pulleys, guides and transport rails, chisels, scrapers, bucket teeth, 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. If more than three passes are required, use **Soudotec 340** or **Soudotec 342** as a cushion.

MECHANICAL PROPERTIES

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")	2.5 mm (3/32")
Amperage:	180 - 230 A	140 - 175 A	110 - 135 A	65 - 100 A

Also available in flux-cored wire: **Soudotec FC 8332W** and solid MIG wire: **Soudotec M600**

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