



398 AC/DC+

HARDFACING

DESCRIPTION

Tubular electrode with steel matrix with a high percentage of **tungsten carbides** for hardfacing mild steel, low-alloy steel and medium carbon content steel parts subjected to **extreme abrasion with no violent impacts**.

CHARACTERISTICS

- 60% tungsten carbide content
- Low heat input due to very low amperage
- All position application
- Dense, smooth, porosity-free and slag-free deposits
- Good resistance to heat
- Non-machinable deposit

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

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Hardness (matrix): Deposit thickness: 60 - 63 HRC + tungsten carbides 2 passes maximum

TYPICAL APPLICATIONS

Forestry equipment, skip bucket blades, conveyor screws, mixer blades, sand pit equipment, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with **Soudotec 212 SP** or **Soudotec G12** electrode. Preheating is recommended for heavy parts. Set the intensity of the current to minimum levels to avoid the fusion of tungsten carbides. Maintain a medium arc with the electrode slightly tilted and with a slight weaving movement. If more than two (2) passes are required, use the **Soudotec 340** or **Soudotec 342** electrode as a cushion. Let cool down slowly.

WELDING PARAMETERS

Diameter: Amperage: 4.0 mm (5/32") 120 –160 A 3.2 mm (1/8") 90 – 120 A

Metal-cored wire also available: Soudotec MC 8398G

Rév.: 21_08

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



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