



399 AC/DC+

HARDFACING

DESCRIPTION

Tubular electrode with Ni-Cr-B-Si matrix and 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. Excellent resistance to acids and other corrosive agents.

CHARACTERISTICS

- 65% 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
- Grindable deposit only (diamond grinder)

Deposit rating scale										
ABRASION										
IMPACT										
HEAT										
CORROSION										
_	1	2	3	4	5	6	7	8	9	10
Jordnoog (matrix):	54 56 HDC Tupgeton earbidge: 2260 HV (Viekere)									

Hardness (matrix): Deposit thickness:

54 - 56 HRC 2 passes maximum Tungsten carbides: 2360 HV (Vickers)

TYPICAL APPLICATIONS

Drilling tools hardfacing and varied parts used in chemical industries, food industries, pulp and paper, aluminum industries, mines, foundries, brickworks, 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 206 electrode as a cushion. Let cool down slowly.

WELDING PARAMETERS

Diameter: Amperage: 5.0 mm (3/16") 110 - 130 A

4.0 mm (5/32") 90 - 110 A

Also available in tubular rods: Soudotec 396 and in metal-cored wire: Soudotec MC 8399G

Rév.: 21 08

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



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