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Soudotec 8105-8108-8112

HARDFACING

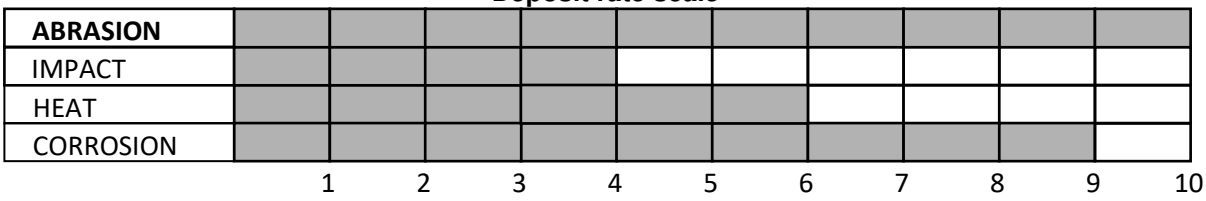
DESCRIPTION

A continuous, flexible cord composed of a nickel-cored wire and a thick coating of Ni-Cr-B-Si alloy matrix wrapped around a **high content** of melted and crushed **tungsten carbide particles**. Recommended for hardfacing carbon steel, low alloy steel, high alloy steel, stainless steel and cast iron parts subjected to **severe abrasion** and **corrosive acids and/or agents**.

CHARACTERISTICS

- **65% tungsten carbide content**
- Formation of a compact and homogeneous deposit that bonds to the base metal
- Easy application with an oxyacetylene torch
- Good corrosion and heat resistance, up to 450°C (840°F)

Deposit rate scale



Hardness (matrix): 40 HRC
Tungsten carbides: **2000 - 2500 HV**
Deposit thickness: 1 pass (3 mm (1/8'') thickness) or 2 passes (5 mm (3/16'') thickness)

TYPICAL APPLICATIONS

Protection of new and/or worn parts. Miscellaneous applications in industries faced with severe abrasion problems: ceramics, foundries, cement factories, paper mills, drilling, etc. Augers, valves, molds, elbows, pallets, scrapers, grader blades, couplings, rakes, dust collector fans, etc.

PROCEDURE

Clean the surface with a grinding wheel to remove any trace of grease, oil, dirt or oxides since these products only adhere to clean surfaces. Preheat the surface to be hardfaced to about 400-450°C (752-842°F) until the steel becomes light blue. Adjust the torch to obtain a low carburizing flame. Push the flexible cord through the handle to keep the hand well clear of the flame. Braze the cord on the surface to be hardfaced (cord and torch at a 45° angle with respect to the surface). Do not overheat the workpiece in order to prevent the carbide particles from coming up to the surface of the deposit. For improved adherence, we recommend applying a layer of **Fusetec** metal powder or **Soudotec F081** flux before depositing the cord.

WELDING PARAMETERS

Diameter:	6.3 mm (1/4'')	5.0 mm (3/16'')	
Type of flame:	Low carburizing		
Granulometry:	8105 = Fine particles	8108 = Medium particles	8112 = Coarse particles

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