



FC 8340 DC+

BUILD-UP

DESCRIPTION

Open arc flux-cored Cr-Ni-Mn wire for **joining and building-up** carbon steels, low alloy and 11-14% manganese steels (Hadfield steels). Ideal as a cushion before hardfacing. Excellent resistance to **severe impacts** with **moderate abrasion** and **corrosion**.

CHARACTERISTICS

- Multi-pass deposit
- No shielded gas required
- Work hardening and machinable Cr-Ni-Mn deposit
- High deposit rate

Deposit rating scale

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

Tensile strength: 125 000 psi (865 MPa)
 Hardness (as-welded): 250 BH Work-hardened: 550 BH
 Deposit thickness: Unlimited

TYPICAL APPLICATIONS

Low alloy steel to manganese steel assemblies. Idlers, bottom and tread rolls, railroad crossings, switches and frogs, crusher rolls and cones, bucket teeth, etc. Excellent as a cushion wire before hardfacing.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12** electrode. When using a constant current power supply (generator), it is preferable to use a shielded gas (75 % Ar – 25 % CO₂) to improve the arc stability.

WELDING PARAMETERS

Diameter:	7/64" (2.8 mm)	3/32" (2.5 mm)	1/16" (1.6 mm)	.045" (1.2 mm)
Voltage:	28 - 32 V	28 - 32 V	26 - 30 V	26 - 30 V
Amperage:	300 - 450 A	280 - 430 A	210 - 280 A	110 - 200 A
Stick-out:	2" - 3"	2" - 3"	1½" - 2½"	1" - 2"

Packaging: Spool: 1.2 mm - 1.6 mm; Coil: 1.6 mm - 2.5 mm - 2.8 mm; Drum on request

Electrodes also available: **Soudotec 342**

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