



FC 8342W DC+

BUILD-UP

DESCRIPTION

Gas shielded flux-cored wire with slag for economical build-up and hardfacing on carbon and alloy steels, subjected to moderate abrasion and impacts. Excellent as a cushion before hardfacing with Soudotec FC 8332 W.

CHARACTERISTICS

- Multi-pass deposit
- Low spatter
- Machinable deposits
- Smooth deposit and easy slag removal
- Dense and porosity-free deposits

Deposit rating scale

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

Hardness (as-welded): 40 HRC
 Deposit thickness: Unlimited

TYPICAL APPLICATIONS

Buckets, shovels, rollers and some crusher parts, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the Soudotec 212 SP or Soudotec G12 electrode.

WELDING PARAMETERS

Gas: 100 % CO₂ or 75 % Ar + 25 % CO₂ (75/25 slightly increase hardness)
 Diameter: 1/16" (1.6 mm) .045" (1.2 mm)
 Voltage: 23 - 28 V 21 - 26 V
 Amperage: 175 - 250 A 150 - 225 A
 Stick-out: 1/2" - 1" 1/2" - 1"
 Packaging: Spool of 4.5 kg and 11.4 kg: 1.2 mm and 1.6 mm

Electrodes also available: **Selectarc HB 40**

Rev. : 21_08

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