


MC 8306G DC+
HARDFACING
DESCRIPTION

Gas shielded metal-cored wire (MCAW) **without slag** composed of a **machinable** cobalt base alloy of grade 6 for hardfacing steel, stainless steel, cast iron and nickel alloy parts subjected to **very high temperatures** in presence of **corrosion, impacts, abrasion** and/or **metal-to-metal friction**.

CHARACTERISTICS

- **Ductile and machinable deposits**
- Maintains excellent hardness at high temperatures
- Smooth, stable arc and low spatter
- Good corrosion and heat resistance, up to 800°C (1472°F)

Deposit rating scale

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

Hardness (as-welded) : 42 - 45 HRC

at 600°C (1112°F): 30 HRC

Deposit thickness : 2 passes maximum

TYPICAL APPLICATIONS

Extrusion screw, valve seats and sealing surface, augers, hot shear blades, ingot tong ends, hotpressing tools, beaters for coke pulverisers, etc

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. To avoid cracking and facilitate spreading of the filler metal, preheat the parts according to their thickness and composition and maintain the same temperature during hardfacing operations. Low amperage welding required limiting dilution. If you have cracks use **Soudotec 212 SP** or **Soudotec G12** to gouge them.

WELDING PARAMETERS

Gas: 98 % Ar - 2 % O₂ or 75 % Ar - 25 % CO₂
 Diameter : 1.2 mm (.045")
 Voltage : 23 - 32 V
 Amperage : 190 - 260 A
 Stick-out : 1" - 1½"
 Packaging : Spool of 15 kg

Also available in electrodes: **Selectarc Co6** and TIG rods: **Selectarc 6G**

Rév.: 21-08

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

FSH WELDING Canada

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