


MC 8204G DC+
ALLOY STEEL
DESCRIPTION

Gas shielded metal cored (MCAW) for joining and repairing high carbon steels, armor plate, difficult-to-weld steels and manganese steels.

CHARACTERISTICS

- Good crack-resistant deposit
- Excellent mechanical properties
- Work hardening deposit
- Excellent corrosion, oxidation and thermic shock resistance up to 600 °C (1112°F)
- High deposit rate without slag

TYPICAL APPLICATIONS

Excellent for dissimilar assemblies, armor plate, austenitic manganese steel, propellers, pumps, valves, frames, shafts, impellers, housings, etc. Also excellent as a cushion 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. Remove slag between each pass. Let cool slowly. For some high alloy steels, preheating is recommended.

MECHANICAL PROPERTIES

| | | |
|-------------------|----------------------|-----------------------|
| Tensile strength: | 95 000 psi (660 MPa) | |
| Yield strength: | 69 000 psi (475 MPa) | |
| Elongation: | 38 % | |
| Hardness: | 250 BH | Work-hardened: 500 BH |

WELDING PARAMETERS

Gas: 100 % CO₂ ou 75 % Ar + 25 % CO₂

| | | |
|----------------------|---------------------|---------------------|
| Diameter : | 1.2 mm .045" | 1.6 mm 1/16" |
| Amperage: | 180 – 300 A | 190 – 490 A |
| Voltage: | 21 – 28 V | 24 – 32 V |
| Stick-out : | 1/2" à 5/8" | 3/4" à 1" |
| Gas (p.c.h) : | 40 - 55 | 40 - 55 |

Packaging: 15 kg spool

Rev.: 21_08

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