



329

HARDFACING

DESCRIPTION

Composite rod made up of **tungsten-carbide** particles retained in a resilient bronze-nickel matrix for flame hardfacing of steel, stainless steel, cast iron and/or nickel-alloy steel parts subjected to **extreme abrasion** and **moderate impacts**.

CHARACTERISTICS

- No dilution with base metal
- Good weldability
- Good matrix retention properties and therefore no carbide detachment
- Excellent filler metal anchorage
- Instantaneous first-pass hardness
- Rough deposit

Deposit rating scale

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

Hardness (matrix): 200 BH + tungsten carbides
 Deposit thickness: 3 passes maximum

TYPICAL APPLICATIONS

Building up of drills, reaming bits, post-hole diggers, stabilizers, grinding tools, concrete mixers, shredding knives, shovels, boring bits, rotary cutting tools, concrete bits, etc. Farming and oil industries, cement manufacturers, dredging, trenching, etc.

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Heat the surface with a torch using a neutral flame and apply **Soudotec 57 FC** flux coated rod as a cushion. Heat the surface again, and melt **Soudotec 329** electrode by positioning the flame on it. Avoid overheating the base metal. Let cool down slowly.

WELDING PARAMETERS

Carbide diameters: 5 mm (3/16") x 3.2 mm (1/8")
 Rod diameter: approximately 12.7 mm (1/2")
 Bonding temperature: 760 - 870°C (1400 - 1600°F)
 Type of flame: Neutral

Rév.: 21_08

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