



**333 SP** AC/DC+

**HARDFACING**

**DESCRIPTION**

Very high-recovery (200%) slag-free electrode with complex chromium, niobium, tungsten, molybdenum and vanadium carbides for hardfacing mild steel, low alloy steel, stainless steel and manganese steel parts subjected to **extreme abrasion, heat and moderate impacts.**

**CHARACTERISTICS**

- Heat and corrosion resistance, up to 550°C (1022 °F)
- Slag-free deposit
- Smooth and regular fusion
- High wear-resistant complex carbide alloys
- Very high deposit rate

Deposit rating scale

<b>ABRASION</b>																				
<b>IMPACT</b>																				
<b>HEAT</b>																				
<b>CORROSION</b>																				
	1	2	3	4	5	6	7	8	9	10										

Hardness (as-welded): 65 - 67 HRC  
 Deposit thickness: 2 passes maximum

**TYPICAL APPLICATIONS**

Mixer blades, refractory press screws, plow blades, scrapers, bucket teeth, gate valves, ore crushers, wear plates, 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. Maintain a medium arc with the electrode slightly tilted. If more than two passes are required, use **Soudotec 340** or **Soudotec 206** as a cushion.

**WELDING PARAMETERS**

Diameter:	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	190 - 260 A	140 - 190 A	120 - 150 A

Flux-cored wire also available: **Soudotec FC 8333**

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



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