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Soudotec

340 AC/DC+

BUILD-UP

DESCRIPTION

Electrode specifically designed for building up manganese steels (11-14% Mn), low carbon steels and low alloy steels subjected to **severe impacts** and **moderate abrasion**.

CHARACTERISTICS

- **Ideal as a cushion before hardfacing with Soudotec 330**
- Machinable and work hardening deposits
- All-position electrode with stable arc
- Multi-pass deposits
- Porosity-free deposits

Deposit rating scale

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

Hardness (as-welded): 250 BH Work hardening : 550 BH
Deposit thickness: unlimited

TYPICAL APPLICATIONS

Bucket lips/teeth, crusher hammers/rollers, rails, railway switches, mining and excavation equipment, 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. Remove slag between each pass.

WELDING PARAMETERS

Diameter:	6.3 mm (1/4")	5.0 mm (3/16")	4.0 mm (5/32")	3.2 mm (1/8")
Amperage:	175 - 250 A	150 - 200 A	130 - 160 A	100 - 150 A

Flux-cored wire also available: **Soudotec FC 8342**

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

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