



342 AC/DC+

BUILD-UP

DESCRIPTION

High-recovery electrode (140 %) for **joining and build-up** of carbon steels, low alloy and 11-14% manganese steels (Hadfield steels). Ideal as a cushion before hardfacing. Excellent resistance to **severe impacts** with **moderate abrasion** and **corrosion**.

CHARACTERISTICS

- Multi-pass deposit
- High chromium content
- Work hardening and machinable Cr-Ni-Mn deposit
- Excellent mechanical properties

Deposit evaluation scale

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

Tensile strength: 125 000 psi (865 MPa)
 Yield strength: 87 000 psi (600 MPa)
 Hardness (as-welded): 250 BH Work-hardened: 550 BH
 Deposit thickness: Unlimited

TYPICAL APPLICATIONS

Low alloy steel - manganese steel assemblies. Idlers, bottom and tread rolls, railroad crossings, switches and frogs, crusher rolls and cones, bucket teeth, etc. Excellent as a cushion before hardfacing with all electrode types.

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: 5.0 mm (3/16") 4.0 mm (5/32") 3.2 mm (1/8")
 Amperage: 210 - 230 A 150 - 170 A 120 - 140 A

Flux-cored wire also available: **Soudotec FC 8340**

Rev. : 21_08

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