



344 AC/DC+

HARDFACING

DESCRIPTION

All-position hardfacing electrode containing **fine carbides of tungsten, chromium and vanadium**, for hardfacing carbon steel, low-alloy steel, cast steel and manganese steel parts subjected to **abrasion, moderate impact, and metal-to-metal friction up to 550°C (1022°F)**.

CHARACTERISTICS

- Excellent all-position weldability, even on AC power supply
- Crack-free deposit
- Smooth arc and spatter-free
- Dense, machinable and porosity-free deposits
- Easy slag removal

Deposit rating scale

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

Hardness (as-welded): 42 - 45 HRC
 Deposit thickness: 5 passes maximum

TYPICAL APPLICATIONS

Scrap cutting shears, trimming and blanking dies, shear blades; forging dies, cold and hot working dies, hammer dies, etc.

PROCEDURE

Remove any trace of oil, grease and/or dirt from the surface. Remove damaged metal with **Soudotec 212 SP** or **Soudotec G12**. Keep a short arc with the electrode slightly inclined. Remove slag between passes. Cool slowly. Depending of the base metal a preheating can be necessary.

WELDING PARAMETERS

Diameter: 4.0 mm (5/32") 3.2 mm (1/8")
 Amperage: 150 - 170 A 105 - 125 A

Rev. : 21_08

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