



345 AC/DC+

TOOL SURFACING

DESCRIPTION

Superior **high-alloy** electrode in the high-speed steel category for hardfacing, building up and manufacturing tool steels. Excellent **heat** and **metal-to-metal frictional wear** resistance.

CHARACTERISTICS

- Good hardness up to 560°C (1040°F)
- Excellent all-position weldability
- Good resistance to impacts and abrasion
- Dense and porosity-free deposits
- Deposits can be heat treated

Deposit rating scale

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

Hardness (as-welded): 62 HRC

After heat treatment: 64 - 65 HRC

Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Excellent for building up cutting and machining tools, cold shear blades, threaders, milling tools, drills, drill bits, sharp edges, debarking tools, punching dies, stamping dies and any parts subjected to metal-to-metal frictional wear. Recommended for use on M1, M2, D2 steels, etc.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal and cracks with the **Soudotec 212 SP** or **Soudotec G12**. Preheat thick parts at 250 to 500°C (480 to 940°F). Weld 2" to 3" (5.5 – 7.5 cm) beads with a short arc, without weaving. Weld quickly to avoid overheating the base metal. Remove slag between passes. For parts affected by moderate impacts use **Soudotec 265** electrode as a cushion.

WELDING PARAMETERS

Diameter: 3.2 mm (1/8") 2.5 mm (3/32")
 Amperage: 75 – 125 A 55 – 90 A

Also available in short electrodes (229 mm (9")): **Soudotec 345 S** (diameter 2.5mm (3/32")), TIG rods: **Soudotec T345** and metal-cored wire: **Soudotec MC 8345G**.

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