



346 AC/DC+

HARDFACING

DESCRIPTION

High alloy tubular electrode containing chromium carbide for hardfacing steel, stainless steel and cast iron parts subjected to **severe abrasion**, **corrosion** and **moderate impacts**.

CHARACTERISTICS

- Superior deposit rate at very low amperages and in all positions
- Low dilution rate
- Low heat input, reducing deformation and cross-checking
- Moisture-resistant coating
- Smooth and shiny slag-free deposit with high chromium carbide content

Deposit rating scale

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

Hardness (as-welded): 58 – 62 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Crusher jaws/hammer, bucket teeth, scraper blades, conveyor chains, augers, buckets, 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: | 12.7 mm (1/2") | 8.0 mm (3/8") | 6.3 mm (1/4") |
| Amperage: | 250 - 400 A | 140 - 200 A | 90 - 140 A |

Rev.: 21_08

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