



397

**HARDFACING**

**DESCRIPTION**

Tubular rod with steel matrix with a high percentage of **tungsten carbides** for hardfacing mild steel, low-alloy steel and medium carbon content steel parts subjected to **extreme abrasion with no violent impacts**.

**CHARACTERISTICS**

- 60% tungsten carbide content
- Can be used with a torch or TIG
- No dilution with base metal (application with torch)
- Dense, smooth and porosity-free deposits
- Instantaneous first-pass hardness
- Non-machinable deposit

Deposit rating scale

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

Hardness (matrix): 58 - 60 HRC + tungsten carbides  
 Deposit thickness: 2 passes maximum

**TYPICAL APPLICATIONS**

Horse shoes, augers, drilling heads, knives, shredding knives, etc.

**PROCEDURE**

Remove any trace of oil, grease and dirt from the surface. Grind and smooth rugged corners. Preheating between 245 – 300°C (500 – 600°F) can be recommended depending on the thickness and composition. Use a slightly carburizing flame. Avoid overheating the base metal. Let cool down slowly.

**WELDING PARAMETERS**

Diameter: 4.0 mm (5/32") 3.2 mm (1/8")  
 Bonding temperature: 855 - 970°C (1600 - 1800°F)  
 Type of flame: Slightly carburizing

Rév.: 21\_08

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



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