



FC 8332W DC+

HARDFACING

DESCRIPTION

Gas shielded flux-cored wire with slag for economical hardfacing on carbon and alloy steel, subjected to moderate abrasion, moderate impact and metal-to-metal frictional wear.

CHARACTERISTICS

- Dense and porosity-free deposit
- Low spatter
- Grindable deposit only
- All-position welding
- Smooth deposit and easy slag removal

Deposit rating scale

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

Hardness (as-welded): 55 - 60 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Bulldozer blades, conveyor screws, body pumps, bucket teeth, hammers, etc.

PROCEDURES

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the Soudotec 212 SP or Soudotec G12 electrode. If necessary, use Soudotec FC 8342W as a cushion before hardfacing.

WELDING PARAMETERS

Gas: 100 % CO₂ or 75 % Ar + 25 % CO₂ (75/25 slightly increase hardness)
 Diameter: 1/16" (1.6 mm) .045" (1.2 mm)
 Voltage: 23 - 28 V 21 - 26 V
 Amperage: 175 - 250 A 150 - 235 A
 Stick-out: 1/2" - 1" 1/2" - 1"
 Packaging: Spool of 4.5 kg and 11.4 kg : 1.2 mm - 1.6 mm.

Electrodes also available: Soudotec 390 and solid MIG wire: Soudotec M600

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