



FC 8332 DC+

HARDFACING

DESCRIPTION

Open arc flux-cored wire containing chromium carbides for **economical hardfacing** on mild, low alloy, and manganese steel subjected to **severe abrasion** and **moderate impacts**.

CHARACTERISTICS

- **Smooth and dense deposit**
- No shielded gas required
- Grindable deposit only
- High deposit rate

Deposit rating scale

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

Hardness (as-welded): 40 - 45 HRC Work-hardened: 50 - 55 HRC
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Drag buckets, crusher jaws, rollers and cones, bucket teeth, conveyor screws, mixing blades, concrete pumps, 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. Use **Soudotec FC 8342** as a cushion before hardfacing with **Soudotec FC 8332**. When using a constant current power supply (generator), it is preferable to use a shielded gas (75 % Ar – 25 % CO₂) to improve the arc stability.

WELDING PARAMETERS

Diameter: 7/64" (2.8 mm) 3/32" (2.5 mm) 1/16" (1.6 mm) .045" (1.2 mm)
 Voltage: 30 - 34 V 28 - 32 V 26 - 30 V 26 - 30 V
 Amperage: 270 - 400 A 250 - 380 A 200 - 370 A 120 - 160 A
 Stick-out: 2" - 3" 2" - 3" 1½" - 2½" 1" - 2"
 Packaging: Spool : 1.2 mm - 1.6 mm ; Coil : 2.5 mm - 2.8 mm ; Drum on request

Rev.: 21_08

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