



**FC 8333** DC+

**HARDFACING**

**DESCRIPTION**

Open arc flux-cored wire containing uniformly distributed **complex carbides** in a hard matrix. Ideal for hardfacing on mild and low alloy steel, stainless steel and manganese steel subjected to **severe abrasion, heat and moderate impact**.

**CHARACTERISTICS**

- Heat resistance up to 705°C (1300°F)
- No shielded gas required
- Grindable deposit only
- Chromium and niobium carbide alloys
- High deposit rate

Deposit rating scale

<b>ABRASION</b>	1	2	3	4	5	6	7	8	9	10
<b>IMPACT</b>										
<b>HEAT</b>										
<b>CORROSION</b>										

Hardness (as-welded): 62 - 64 HRC  
 Deposit thickness: 2 passes maximum

**TYPICAL APPLICATIONS**

Endless screws and other screws, crusher parts, blades, furnace parts, chutes, elbows, pumps, rolls, chains, scrapers, 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 8340** as a cushion before hardfacing with **Soudotec FC 8333**. When using a constant current power supply (generator), it is preferable to use a shielded gas (75 % Ar – 25 % CO<sub>2</sub>) 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:	28 - 34 V	28 - 32 V	26 - 30 V	24 - 30 V
Amperage:	250 - 375 A	240 - 365 A	210 - 275 A	120 - 160 A
Stick-out:	2" - 3"	2" - 3"	1½" - 2½"	1" - 2"
Packaging:	Spool : 1.2 mm - 1.6 mm ; Coil : 1.6 mm - 2.5 mm - 2.8 mm ; Drum on request			

Electrodes also available: **Soudotec 333 SP**

Rev.: 21\_08

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