



FC 8342 DC+

BUILD-UP

DESCRIPTION

Open arc flux-cored wire for **economical build-up** on mild, low alloy and manganese steels. Excellent as a cushion before hardfacing with **Soudotec FC 8332**. Excellent resistance to **severe impacts** with **moderate abrasion**.

CHARACTERISTICS

- Flame cuttable deposit
- Multi-pass deposit
- No shielded gas required
- Work hardening and machinable deposit
- High deposit rate

Deposit rating scale

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

Hardness (as-welded): 170 - 200 BH Work-hardened: 425 - 480 BH
 Deposit thickness: Unlimited

TYPICAL APPLICATIONS

Crusher rolls and cones, bucket teeth, hammers; crossings, frogs and switches, 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. 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:	28 - 30 V	28 - 30 V	26 - 28 V	24 - 26 V
Amperage:	270 - 350 A	250 - 330 A	170 - 260 A	130 - 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 340**

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



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