



M300 DC+

BUILD-UP

DESCRIPTION

General purpose **solid** (GMAW) MIG **copper coated machinable wire**, for **economical** build-up and cushions before hardfacing of parts subjected to **impact** and **compression**.

CHARACTERISTICS

- **Slag free deposit**
- Low spatter
- More than 99 % efficiency
- Can be used out of position
- Smooth and very good bead appearance
- High welding speed

Deposit evaluation scale

ABRASION										
METAL-METAL										
COMPRESSION										
IMPACTS										
	1	2	3	4	5	6	7	8	9	10

Hardness (as-welded): 300 BH (~32 HRC)
 Deposit thickness: Unlimited

TYPICAL APPLICATIONS

Heavy building up and cushion layer on forging die cavities, mandrels, gear teeth, chains, sprockets, punches, blades, drawing dies.

PROCEDURE

Remove any trace of oil, grease and dirt from the surface. Remove damaged metal with the **Soudotec 212 SP** or **Soudotec G12** electrode.

WELDING PARAMETERS

Gas: Ar-CO₂ mixture or 100% CO₂
 Diameter: 1.2 mm (.045")
 Amperage: 120 - 250 A
 Voltage: 18 - 32 V
 Stick-out: 1" - 1 1/2"
 Gas flow rate (c.f.h) : 30 - 40
 Packaging: Spool of 4.5 kg and 15 kg

Electrodes also available: **Selectarc HB 300B**

Rév.: 21_08

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