



**MC 8332WSH DC+**

**TOOLS SURFACING**

**DESCRIPTION**

Superior **high-alloy gas shielded** metal-cored wire (MCAW) for **hardfacing** on carbon and alloy steel, subjected to **abrasion, impact** and **metal-to-metal frictional wear**.

**CHARACTERISTICS**

- **Dense and porosity-free deposit with a tungsten and molybdenum addition**
- Low spatter
- Grindable deposit only
- All-position welding
- Smooth deposit and easy slag removal

Deposit rating scale

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

Hardness (as-welded): 60 - 65 HRC  
 Deposit thickness: 2 - 3 passes maximum

**TYPICAL APPLICATIONS**

Tires shredding hook knives, conveyor screws, moulds, pump housing, hammers, cold shear blades.

**PROCEDURE**

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 8277G** as a cushion before hardfacing.

**WELDING PARAMETERS**

Gas: 100 % CO<sub>2</sub> or Ar / CO<sub>2</sub> mixture  
 Diameter: .045" (1.2 mm)  
 Voltage: 19 - 22 V  
 Amperage: 180 - 200 A  
 Stick-out: ½" - ¾"  
 Packaging: Spool of 11.4 kg

Rev.: 21\_08

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



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