



**MC 8345G DC+**

**TOOLS SURFACING**

**DESCRIPTION**

Superior **high-alloy gas shielded** metal-cored wire (MCAW) in the high-speed steel category for hardfacing, building up and manufacturing tool steels. Excellent **heat** and **metal-to-metal frictional wear** resistance. **Slag-free** deposit.

**CHARACTERISTICS**

- Good hardness up to 620°C (1150°F)
- Excellent weldability in position
- Good resistance to impacts and abrasion
- Dense and porosity-free deposits
- Deposits can be heat treated

Deposit rating scale

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

Hardness (as-welded): 61 - 65 HRC  
 Deposit thickness: 2 - 3 passes maximum

**TYPICAL APPLICATIONS**

Excellent for building up cutting and machining tools, cold shear blades, threaders, milling tools, drills, drill bits, sharp edges, debarking tools, punching dies, stamping dies and any parts subjected to metal-to-metal frictional wear. Recommended for use on M1, M2, D2 steels, 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. Preheat thick parts at 250 to 500°C (480 to 940°F). Weld 2" to 3" (5.5 - 7.5 cm) beads, without weaving. For parts affected by moderate impacts use **Soudotec FC 8265G** as a cushion before hardfacing with **Soudotec MC 8345G**.

**WELDING PARAMETERS**

Gas: Ar / CO<sub>2</sub> mixture  
 Diameter: 1/16" (1.6 mm) .045" (1.2 mm)  
 Voltage: 20 - 23 V 19 - 22 V  
 Amperage: 170 - 210 A 160 - 200 A  
 Stick-out: 1/2" - 3/4" 1/2" - 3/4"  
 Packaging: Spool of 11.4 kg : 1.2 mm - 1.6 mm

Electrodes also available: **Soudotec 345** and **Soudotec 345 S**

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



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