



MC 8398G DC+

HARDFACING

DESCRIPTION

Gas shielded metal-cored wire (MCAW) with a steel matrix **without slag**, with a **high content of tungsten carbides** particles for hardfacing on carbon or low alloy steel and medium carbon content steel subjected to **extreme abrasion with no violent impacts**.

CHARACTERISTICS

- **Very fast process to apply tungsten carbides**
- Low spatter
- Grindable deposit only (diamond grinder)
- Good heat resistance

Deposit rating scale

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

Hardness (deposit): 66 - 68 HRC
 Deposit thickness: 2 passes maximum
 Tungsten carbides: **2360 HV (Vickers)**

TYPICAL APPLICATIONS

Forestry equipment, skip bucket blades, conveyor screws, mixer blades, sand pit equipment, 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.

WELDING PARAMETERS

Gas: Ar-CO₂ mixture
 Diameter: 1/16" (1.6 mm)
 Voltage: 24 - 26 V
 Amperage: 180 - 220 A
 Stick-out: 1" - 1½"
 Packaging: Spool of 5 kg and 15 kg : 1.6 mm

Tubular electrodes also available: **Soudotec 398** and tubular rods: **Soudotec 397**

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



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