



MC 8399G

DC+

HARDFACING

DESCRIPTION

Gas shielded metal-cored Ni-Cr-B-Si wire (MCAW) without slag, with a high content of tungsten carbide particles for hardfacing on carbon or low alloy steel, austenitic and ferritic steel, subjected to extreme abrasion, acids and other corrosive agents.

CHARACTERISTICS

- Very fast process to apply tungsten carbides
- Low spatter
- Grindable deposit only (diamond grinder)
- All-position welding
- Heat resistance up to 450°C (842°F)

Deposit rating scale

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

Hardness (matrix): 54 - 56 HRC Tungsten carbides: **2360 HV (Vickers)**
 Deposit thickness: 2 passes maximum

TYPICAL APPLICATIONS

Drilling tools hardfacing and varied parts used in chemical industries, food industries, pulp and paper, aluminum industries, mines, foundries, brickworks, 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: 75 % Ar - 25 % CO₂ or 99 % Ar – 1 % O₂
 Diameter: 1.2 mm (0.45") 1.6 mm (1/16")
 Voltage: 16 - 20 V 24 – 26 V
 Amperage: 120 - 160 A 180 – 220 A
 Stick-out: 1" - 1½" 1" – 1 1/1"
 Packaging: Spool of 5 kg and 15 kg

Also available in tubular rods: **Soudotec 396** and tubular electrodes: **Soudotec 399**

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