

## FILLER METAL SELECTION TABLE FOR BUILD UP AND HARDFACING

M600	57	3	✓			✓														
M300	32	Unlimited	✓				✓		✓				✓							
8306G	42-45	2	✓			✓							✓	✓						
81XX - 8399G	54-56 +WC	2				✓												✓	✓	✓
399	54-56 +WC	2				✓							✓	✓				✓	✓	✓
398 - 8398G	60-63 +WC	2	✓			✓							✓	✓				✓	✓	✓
397	58-60 +WC	2				✓												✓	✓	
8332W - 390	55-60	2-3			✓	✓								✓			✓			✓
359	58-62	2				✓														✓
346	58-62	2	✓	✓		✓							✓	✓			✓			✓
8345G - 345S - 345	62	2			✓	✓								✓						✓
344	42-45	5			✓	✓				✓				✓			✓			✓
8340 - 342	250 (BH)	Unlimited	✓	✓	✓		✓	✓	✓	✓										✓
8342 (W) - *340	170-395 (BH)	Unlimited			*✓		✓	✓	✓	✓				✓						✓
336	62-64	2	✓	✓		✓												✓		✓
8333 - 333 SP	62-67	2	✓	✓		✓												✓		✓
333	62-65	2	✓	✓		✓												✓		✓
8332	40-45	2		✓	✓	✓			✓		✓							✓		✓
330- 8330- *8330 SP	58-63 *52	2 *3-5		✓	✓	✓				✓								✓		✓
329	200 BH +WC	3				✓												✓		✓ Tor
Co6 - 6G	40-45	2			✓	✓				✓				✓	✓					✓ 6G
Co1 - 1G	53-57	2			✓	✓														✓ 1G
<b>PRODUCTS</b>																				
<b>PROPERTIES</b>	Hardness (as-welded) (HRC)	Deposit thickness (number of passes)	High-recovery (coated electrodes)	Slag free	Contact electrodes	Can be used for assemblies	Build up and cushion before hardfacing	Hardfacing	Work hardening deposit	Machinable deposits Available in flux-cored wire: 0.045 - 1.5mm	Low amperage tubular electrode	All-position	Cobalt base alloys	Chromium carbide base alloys	Tungsten carbide base alloys	Coated electrode and/or flux-cored wire	TIG or torch			

✓ = Recommended product(s)

NOTE: Electrode hardness values may vary depending on the hardness value of the flux cored wire used. For more information, consult the Technical Data Sheet for the specific product.