



M600 DC+

HARDFACING

DESCRIPTION

General purpose solid GMAW (MIG) copper coated wire for economical hardfacing on parts subjected to abrasion, impacts or metal to metal friction.

CHARACTERISTICS

- Slag-free deposit
- Low spatter
- More than 99 % efficiency
- Excellent performance in horizontal position
- Smooth and very good bead appearance
- Grindable deposit only

Deposit rating scale

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

Hardness: 600 BH (~ 57 HRC)
 Deposit thickness: 2 - 3 passes maximum

TYPICAL APPLICATIONS

For the hardfacing of excavation parts. Conveyor chains, hammers, drills, crusher parts, cutting tools, 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. If more than 3 passes are required, use Soudotec M300 as a cushion before hardfacing.

WELDING PARAMETERS

Gas : Ar - CO2 mixture or 100% CO2
 Diameter : 1.2 mm (.045") 1.0 mm (.040")
 Amperage : 150 - 220 A 150 - 170 A
 Voltage : 26 - 28 V 25 - 28 V
 Stick out : 1/2" - 3/4" 1/2" - 3/4"
 Gas flow rate (c.f.h) : 30 - 40 30 - 40

Also available in electrodes: Soudotec 390 and flux-cored wire: Soudotec FC 8332W

Rév.: 21_08

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



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