

TUBEFACE 308

**HIGH DEPOSITION, HIGH EFFICIENCY BUILD UP
ALLOY FOR SEVERE IMPACT RESISTANCE**

FLAME CUTTABLE

SPECIAL CHARACTERISTICS:

- * All position * Moisture Resistant Coating * High Efficiency
- * AC/DC Operation * High Deposition * Requires Low Amperage
- * Low Dilution * Low Heat Input

GENERAL CHARACTERISTICS:

Tubeface 308, Tubular hardfacing electrode is designed for jobs requiring high deposition rates and economical deposits for high impact applications. This all position electrode deposits a tough, high compressive strength weld metal which resists impact. It can be flame cut and forged. Deposits are nonmagnetic.

APPLICATIONS:

Excellent for rebuilding manganese hammers, rolls, bucket teeth, rails and switches subjected to high impact. Large diameter electrodes can deposit up to 7 pounds per hour. Low amperage requirement limits dilution of the base metal resulting in higher hardness in the weld metal. There is no limit to the deposit thickness.

TECHNICAL DATA:

| | |
|---------------------------------|--------------------------------------|
| Hardness as welded..... | up to RC 18 |
| work hardened | RC 28-45 |
| Tensile Strength | 116,000 psi (800 N/mm ²) |
| Elongation | up to 38% |
| Forgeability | can be forged |
| Machinability | with carbide tools |
| Current | AC or DC either polarity |
| Amperage 80-125 130-200 150-380 | |
| (in) 1/4" 3/8" 1/2" | |
| mm) 6.0 9.0 12.0 | |

PROCEDURE:

Remove all dirt, grease, and surface scale. Remove any brittle work hardened or cracked material with Chamfertrode. Keep weld interpass temperatures as low as possible, do not exceed 500°F. If welding on steels other than manganese steels, a buffer (first) layer of Carbaloy 8 is recommended.