

## TECHNICAL DATA SHEET

 **Starweld 492**

**AC / DC+**

### HARDFACING

#### Description :

All-positions hardfacing electrode containing fine carbides of tungsten, chromium and vanadium, for hardfacing carbon steels, low alloy steel, cast steels and manganese steel parts subjected to abrasion, moderate impacts and metal-to-metal friction up to 550°C (1022°F).

#### Characteristics :

- Excellent all-position weldability even on AC power supply
- Dense, machinable and porosity-free deposits
- Smooth arc and spatter-free deposits
- Easy slag removal
- Crack free deposit

DEPOSIT RATING SCALE	
ABRASION	1 2 3 4 5 6 7 8 9 10
IMPACT	1 2 3 4 5 6 7 8 9 10
HEAT	1 2 3 4 5 6 7 8 9 10
METAL / METAL	1 2 3 4 5 6 7 8 9 10

#### Mechanical properties :

- Polarity AC / DC +
- Hardness (as-welded) : 42 - 45 HRC
- Deposit : 5 Passes maximum

+ **Diameter**  
+ **Amperage**

3.2 mm  
115 A

4.0 mm  
160 A

#### Applications :

Scrap cutting shears, trimming and blanking dies, shear blades, forging dies, cold and hot working dies, hammer dies, etc.

**Also available in metal cored wire : Starweld MC 8344 FFG**

**1 800 361 9097**

 **Starweld**