



Automotive Forging Die

A new generation electrode for surfacing of Cr-Mo alloyed cast iron dies

Typical Applications:

Maintenance and repair welding of blank holders of automotive double action and single action press tools, punches of double action tools subjected to high degree of adhesive wear.

Outstanding Features:

- Suitable for repairing press mould scuffing.
- Deposits are fully machinable with carbide tools.
- Easy operating characteristics in all positions.
- Tough weld deposit with good adhesive wear resistance.

Recommendation:

A new generation electrode suitable for surfacing of Cr-Mo Alloyed Cast Iron Dies.

Procedure:

Recommended is 350° - 400° preheat & job to be done at pre-heat temperature. Completely remove impurities for build-up. A cushion layer with Xuper 22*33N, followed by peening of weld deposit is recommended for sealing of any casting defects.

Recommended Amperages:

Size(mm)	Amperage
3.15	90-130
4.00	130-170

Hardness:

As deposited 42 - 48 HRc (3 layer)