



Trimming Die

Electrode with excellent shearing properties for automotive die applications

Typical Applications:

Repair and built up shearing blades, planer plates, anvils, wood working tools, percussion drills, clamping tools, pressure rollers etc.

Outstanding Features:

- Excellent shearing properties.
- Wear resistance achieved in single layer.
- Deposit with fine grain structure & consistent hardness
- Easy operating characteristics in all positions.

Recommendation:

A new generation electrode suitable for surfacing of automotive trimming and flanging dies subjected to adhesive wear during cold working of sheet metal.

Procedure:

Use short arc to deposit stringer beads. Clean the weld area. In general, it is not necessary to preheat, but if the base material is highly carbonized, it should be preheated to approximately 200°C. Cushioning layer of Stain Trode D is recommended. Parts can be built up to desired shape by using as many passes as necessary. Final dimensions may be obtained by grinding.

Recommended Amperages:

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

Hardness:

As deposited 54 - 58 HRC (3 layer)