



Stamping Die

New Generation Electrode for Surfacing and Build-up of Dies & Tools

Typical Applications:

Repair and buildup of all hot tool steel and cold tool steels dies and tools in Light metal casting, automotive metal working. Forging & Plastic injection moulding industries. Typical applications include aluminum die casting moulds, dies for cutting, trimming, shearing, stamping, forming, extrusion, injection moulding & forging.

Outstanding Features:

- Excellent weldability without pre-heating.
- Weld it - Machine it - Harden it.
- Excellent machinability of welded deposit.
- Low temp PWHT - No risk of distortion.
- High hardness & Wear resistance properties after heat treatment.
- Superior resistance to friction, Adhesion, Impact, heat, thermal fatigue and liquid erosion.
- High temperature fracture toughness & low thermal expansion coefficient.
- Aged martensitic matrix with

uniform distribution of Nano-sized intermetallic phases.

Procedure:

Clean weld area. Pre-heating is generally not required but recommended for high carbon materials and heavy thick sections as per base material. Use a short arc to deposit stringer beads. Parts can be build-up to the desired thickness by giving as many layers as possible. Final dimensions can be obtained by grinding or machining.

Recommended Amperages:

Size(mm)	I-Range
3.15	90-130

Technical Characteristics:

As Welded & PWHT	Hardness(HRC)
Aswelded	38-45
480°Cfor3hours	56-61
520°Cfor3hours	57-63
560°Cfor3hours	58-64