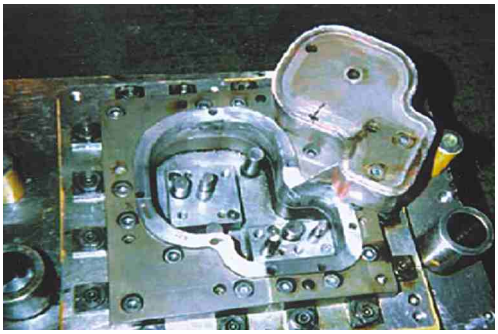
ToolTectic 6HSS ac / dc+



Tool Die

Special electrode for surfacing of cold cutting tool & die application

Typical Applications:

Composite high-speed-steel dies, tools, trimming dies, shears, punches.

Outstanding Features:

- Heat treatable deposits.
- High speed steel overlays.
- Excellent impact & frictional wear resistance property.
- Excellent edge retention property reverent for tool & die application.

Recommendation:

Provides maximum hardness of edges at high temperatures. For use where cutting, shaving, or piercing qualities are required. Excellent for knife edges, and machine tool parts subject to heavy frictional wear. Ideal for building composite blanking or punching dies.

Procedure:

Clean weld area. Preheat larger and complicated sections 200°C - 450°C. On dc, use reverse polarity. Strike arc on scrap steel and carry over to weld area. Deposit 50 - 75 mm at a time, avoiding overheating. Chip slag between beads, and peen to minimize stresses. Post heat large and complicated sections. Use N2222 as a cushion layer.

Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	75 - 90	50 - 65
3.15	105 - 120	80 - 95
4.00	130 - 140	110 - 120

Hardness: 57 - 63 HRc (3 layer)