



Tool Die

## Specially designed electrode for cold cutting tool and die applications.

### 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 required for tool & die applications.

### Recommendation:

Provides maximum hardness of edges at high temperatures. For use where cutting, shaping 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 heads and peen to minimise stresses. Post weld heat treatment for large and complicated sections. Use WUNDER PRO D2 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:** 58-65 HRC (3 layer)