



Tool Die

Special electrode for all position cutting and piercing of all metals

Typical Applications:

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

Outstanding Features:

- Heat treatable deposits.
- High speed steel overlays.
- Excellent cutting, shaving and piercing qualities.

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 Xuper 680 CGS 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)