



NEXA-7080

HOT WORK TOOL STEEL ELECTRODE

ALLOY BASE : Fe, W, Cr, C

PROPERTIES

The deposit is a high quality hot work steel, tough, wear resistant free from crack and porosities. The weld beads are smooth and uniform.

APPLICATIONS

Repair of tools of similar materials or fabrication of hot work tools of carbon steels or low alloy steel. Dies, stampers for non-ferrous metals, saddle tracks, forging hammers, distributor pins, slides, hot shear blades, trimming dies, etc.

PROCEDURES

Preheat bigger jobs to 400-550°C and maintain temperature during welding. Maximum build up permissible is 5 mm. slow cool the job in an oven or under asbestos after weld. The weld deposit can be machined only by grinding. If any other cutting operation is to be performed the deposit need to be annealed.

TECHNICAL DATA

Hardness	as Welded	:	41-46 HRc
	(After Hardening)	:	49-51 HRc
	(After Annealing)	:	21-24 HRc

CURRENT RANGE : DC (+)

SIZE mm	3.15	4.00
CURRENT (Amps)	90-110	140-160