

ToolTecTic 6 NHSS

Manual Metal Arc Electrode For Anti-Wear Coatings

DESCRIPTION

Special quench-hardening electrode providing great hot hardness and thermal oxidation resistance. ToolTecTic 6NHSS is a High-Speed Steel electrode for applications requiring hardened surfaces as welded, which can retain a cutting edge. Heat treatment ensures exceptional mechanical properties in the deposit, with remarkable hot hardness and resistance to high temperature oxidation, making this electrode ideally suited for protection of tool and die steel components. It can also be used for fabrication of cutting tools using medium carbon or low-alloy steels.

Product Details

- Increased service life of coated parts.
- Excellent hot hardness and high temperature oxidation resistance.
- High edge retention characteristics.
- Highly crack resistant.
- Welds in all positions.
- Damaged tools can be repaired rapidly.

APPLICATIONS

Stamping, pressing, drawing and cutting tools; machining steels; hot and cold trimming tools; chisels, forging tools; clutch forks, valves, cams, grabs, mixer blades, feed screws.

PROCEDURE FOR USE

Preparation: Clean the weld area of scale and/or oxide and degrease. Dry penetrant test to locate cracks. Prepare the cracks by grinding to generate a “U” profile. Medium arc. Hold the electrode almost vertical. Preheat slowly according to the grade and heat treated condition of the base material.

TECHNICAL DATA

Typical Hardness : 60-62 HRC
Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	55-70
3.2mm	85-125
4.0mm	115-155

Note: For optimum result use the lowest amperage practical