

EutecTrode EC 6610

Repair And Build-Up Of Drop Forging Tools And Damaged Profiles

DESCRIPTION

Build-up on all drop forging tools. Repair of worn out or damaged profiles. Salvage scrapped undersized die-blocks by total re-build with weld metal. Overlaying of complicated profiles requiring combination of high hardness and toughness combined with good machinability such as gear pinion teeth.

Product Details

- Superior deformation resistance at high temperatures.
- Excellent compatibility with die block steels.
- Machinable with tungsten carbide tool.
- All position weldability.

APPLICATIONS:

Drop forging dies, punches, inserts.

PROCEDURE FOR USE

Clean weld area. Remove all cracked or fatigued metal with ExoTrode.

Pre-heat job to 400°450°C and maintain throughout welding. Deposit with short gap, keeping electrode perpendicular to welding direction. Peening of deposits is essential. Chip slag between passes. After completing deposition, air-cool the job to 200°C to develop uniform hardness. Then transfer to a furnace at 550°C-600°C and temper for 12-16 hours. Remove into still air and cool.

TECHNICAL DATA

Work hardened: 35-45HRC

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
3.2mm	90-130
4.0mm	120-160
5.0mm	150-160

Note: For optimum result use the lowest amperage practical