

# SME D10

## ELECTRODE FOR REBUILDING OF WORNOUT DROP FORGING DIES



### Alloy Basis:

Cr, Ni, Mo,

### Characteristics:

SME D10 has specially designed weld alloy which ensures high strength and toughness at service temperature. The deposits have high impact resistance with good compressive strength. Deposits are machinable by carbide tools.

### Typical Applications:

This electrode is used for rebuilding of worn out drop forging dies & tools, punches, inserts, cast steel gears, pinions and sprockets.

### Mechanical Properties:

Hardness: 38 – 45 HRC

### Welding Current: AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 120	120 - 160	160 - 200

### Availability:

Standard Size: 5.0, 4.0, 3.15 in 350 & 450 mm length.

Packing: 2,5 kgs.

### Procedure:

Clean the area to be welded. Preheat the job at 350 °C – 400 °C. Deposit with short gap and perpendicular to welding direction. Pining of deposits is essential. Air cool the job to 200 °C to develop uniform hardness. Temper at 550 °C - 600 °C for one hour per inch job.