

# SME D35

## ELECTRODE FOR THE REPAIR OF RECLATION OF FORGING DIES



### Alloy Basis:

Cr, Ni, Mo,

### Characteristics:

SME D35 has a superior deformation resistance at high temperature. This electrode has excellent compatibility with die block steels. The alloy present develops a medium wearing machinable deposits.

### Typical Applications:

This electrode is used for overlaying of complicated profiles requiring combination of high hardness and toughness with good machinability.

### Mechanical Properties:

Hardness: 35 – 40 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 400 °C – 450 °C. Deposit with short gap, keeping electrode perpendicular to welding direction. Peening of deposits is essential. After completing deposition, air cool the job to 200 °C to develop uniform hardness. Temper at 550 °C - 600 °C for one hour duration per inch job thickness.