

ELECTRODE FOR DROP FORGING DIES & TOOLS

Alloy Basis:

Cr, Ni, Mo

Characteristics:

SME F01 electrodes are designed where there is a requirement of toughness, wear resistance, resistant to repetitive impact.

Typical Applications:

This electrode is used for build up of gears, pinions, rolls etc. it can also be used for repair of worn out or missing profile.

Mechanical Properties:

Hardness: 38 – 42 HRC

Welding Current: AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 130	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 and start welding so as to maintain temperature range during welding. Deposit with short gap and perpendicular to welding direction. Pining of deposits is essential. After welding air cool the job to about 200 °C to develop uniform hardness.