

## ELECTRODE FOR HOT FORGING DIES

### Alloy Basis:

Cr, Ni, Mo, W

### Characteristics:

SME F05 electrodes are designed for building up of forging dies and tools including H11 and H12. Forging tools are also joined using this electrode.

### Typical Applications:

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

### Mechanical Properties:

Hardness: 48 – 52 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.