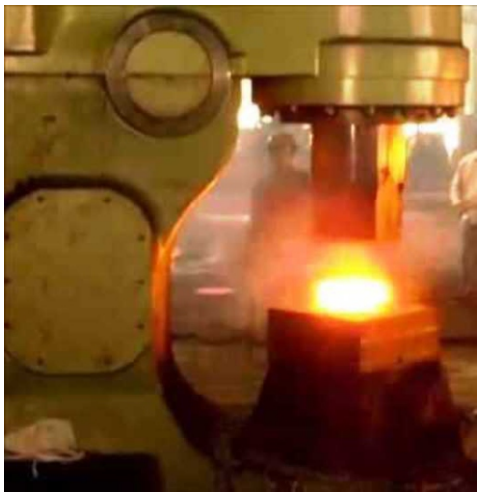
SME G08

Hot Work Tool Steel Electrodes



Alloy Basis

W, Cr

Characteristics :

The weld beads are smooth and uniform. The deposit is a high-quality, tough, wear resistant, free from cracks and porosities..

Typical Application

Used for repair of tools of similar materials or fabrication of hot work tools of carbon steels or low alloy steels, dies, stampers for nonferrous metals, saddle tracks, forging hammers, distributor pins, slides, hot shear blades, trimming dies, etc.

Heat Treatment

Annealing 4 hours at 750-780 °C
Hardening 1070-1120 °C,
Quenching in oil Tempering Two hours at 500-600 °C

Mechanical Properties

Hardness :
As welded 42-46 HRC
(After hardening) 49-51 HRC
(After annealing) 20-24 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 120	120 - 160	170 - 210

Availability:

Standard Size: 5.0, 4.0, 3.15 in 350 mm length
Packing: 2 kg.

Procedure

Clean the weld metal surface, Preheat the job to 300-400 °C. Deposit SME G10 as a base layer for higher thickness and build-ups. Deposit holding the electrode perpendicular to base metal - maximum 2 layers of SME G08 to get full hardness.