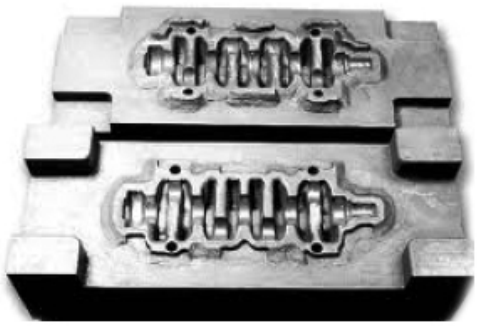
SME G10BF

ELECTRODE FOR SURFACING DIES AND TOOLS, SPECIFICALLY DESIGNED FOR THE DROP FORGING INDUSTRY



Alloy Basis :

Mn, Cr, Ni, Mo, V

Characteristics :

The deposit provides strong resistance to deformation and wear even at elevated temperatures. The weld metal exhibits excellent slag detachability with a smooth and shiny bead appearance. It is machinable with tungsten carbide tools and offers all-position weldability.

Typical Application :

Suitable for joining and buildup on all drop forging tools including punches, dies and inserts. Ideal for filling all types of die impressions or cavities in forging dies, repairing worn-out profiles and rebuilding undersized die blocks.

Mechanical Properties :

Hardness: 38 – 42 HRC

Welding Current : AC, DCEP

Size (Ø mm)	3.15	4.00	5.00
Current (amps)	90 - 120	120 - 150	150 - 190

Availability:

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

Procedure :

Clean the weld metal surface, Preheat the job to about 250 to 350 °C. Use stringer or weaving technique holding a short to medium arc. Finish weld metal by machining to the required size. Do not allow excessive heat buildup. Chip the slag between the passes and allow the deposit to cool. Post heat the job to 450 °C & cool slowly to room temperature.