

SME P50

ELECTRODE FOR REBUILDING OF PRESS FORGING DIES AND TOOLS

Alloy Basis:

Cr, Ni, Mo,

Characteristics:

SME P50 represents an ideal combination of weld alloy which display excellent resiliency high strength and resistance to cracking. The weld deposit has good impact resistance with good compressive strength.



Typical Applications:

This electrode is used for rebuilding of worn out press forging dies & tools, punches, inserts, rolling mill rolls, crane wheels rims, earthmoving undercarriage parts etc.

Mechanical Properties:

Hardness: 42 – 48 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.