

## TUFTOOL 200

A specially formulated low heat input Chromium Vanadium Tungsten based Antiwear surfacing alloy for hot working tools and dies.

### Applications:

Suitable for lining of tools, dies, rotary drills, piercing dies (steel plant, forging, pressure die casting etc.) And mandrels. Specially designed for Rolls of cold rolling mill. Machining is possible with cemented carbide tools.

### Procedure:

Clean weld area, remove all cracked or fatigued metal with Supergouge, maintain interpass temperature of 400<sup>0</sup> C with heavy section. Deposit by using medium to short arc and keep electrode perpendicular to welding direction. Peening of deposit is essential. Chip slag between passes.

### Technical Data

	:			
Hardness	:	RC 50-55		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	90-120	110 -140	150 - 200

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