

DIE – BUILD - S

A yet another basic coated Electrode of this series, designed to give a highly alloyed low carbon weld metal. The weld metal is machinable and exhibits a high degree of toughness, excellent hot strength and wear resistance at elevated temperature along with fine heat cracking resistance. It stands up well against temperature shocks and even admits water cooling from 6000C to 6500C this Electrode is designed to give the most superior weld metal out of the three Electrodes available in the Die Build series. The deposit has an as welded hardness of 41 – 47 RC.

Applications:

Die Build – S is extremely suitable for building up large composite dies or extensive repair of similar dies found in steel, chemical industry, cryogenic as well as nuclear industry.

Procedure:

Remove all fatigue material / work hardened – loose material by gouging or grinding. Heat the base metal 2000C – 3000C depending upon the size and thickness of the die. Use stringer beads and short arc procedure. Weaving should be limited to three times the dia of the electrode. Die Build – S is capable of developing secondary hardening and hardness can be controlled between 38 – 45 Rc by tempering at 6000 C – 6500C. Better results are obtained by double tempering. Soaking period is 1 hr. per 20mm cross section of the die.

<u>TECHNICAL DATA</u>	: DIE BUILD - S
Size (mm), Ø	: 3.15 4.00 5.00
Recommended Welding Current (Amps)	: 85 - 115 100 – 135 130 – 160
Hardness	: 41 – 47 HRC
Tip Colour	: White

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