

Classifications

EN 14700	DIN 8555	Material-No.
S Z Fe5	WSG 3-GZ-350-T	1.6356

Characteristics and field of use

WEARtig Tool 35 is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching dies, cold and hot cutting knives, Al-die cast moulds, cold forging dies, drawing-, stamping- and chamfering tools. The weld deposit is, in as-welded condition, machinable and the subsequent artificial aging optimises the resistance to hot wear and alternating temperatures.

The weld deposit of WEARtig Tool 35 has high strength and good toughness.

Hardness of the pure weld deposit:

untreated 32 – 35 HRC

hot-aged 3 – 4 h / 480°C : 50 – 54 HRC

Typical analysis in %

C	Mo	Ni	Co	Ti	Al	Fe
0.02	4.0	18.0	12.0	1.6	0.1	balance

Welding instruction

Machine welding area to metallic bright finish. Preheat massive pieces to 100 – 150°C, on low-alloyed base metal apply min. 3 – 4 layers. Weld with lowest possible heat input.

Wire diameter [mm]	Current type	Shielding gas (EN ISO 14175)
1.6 x 1000	DC (-)	I 1
2.0 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1