

Classifications

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

Characteristics and field of use

WEARmig 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 WEARmig Tool 35 yields high strength and good toughness values.

Hardness of the pure weld deposit:

As welded: 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 instructions

Machine welding area to a 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)		
1.0*	DC (+)	M 12	M 13	I 1
1.2	DC (+)	M 12	M 13	I 1

*available on request