

Classifications

DIN 8555	EN 14700
E 3-UM-350-T	E Fe5

Characteristics and typical fields of application

Due to its high-grade structure, WEARstick Tool 35 is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching tools, cold shears for thick materials, drawing, stamping and trimming tools, hot cutting tools, Al-die cast moulds, plastic moulds, cold forging tools. The weld deposit is, in as-welded condition, easily machinable and the subsequent age hardening optimises the resistance to wear and alternating temperatures.

WEARstick Tool 35 has excellent welding properties, a smooth and regular drop transfer, good bead appearance and easy slag removal.

Hardness of the pure weld metal:

untreated: 34 – 37 HRC

After age hardening 3 – 4 h / 480 °C: 50 – 54 HRC

Typical analysis

	C	Si	Mn	Ni	Mo	Co	Ti	Fe
wt.-%	0.025	0.2	0.6	20.0	4.0	12.0	0.3	bal.

Operating data

	Polarity	DC +	Dimension mm	Current A
			2.5 × 250	70 – 90
			3.2 × 350	100 – 120
			4.0 × 350	120 – 140

Welding instructions

Clean welding area to metallic bright. Only massive tools should be preheated to 100 – 150 °C. On low-alloy steels at least 3 – 4 layers should be applied. Keep heat input as low as possible.

Approvals

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