

LH 710 BF



SPECIALLY DESIGNED ELECTRODE FOR SURFACING OF DIES AND TOOLS IN FORGING INDUSTRY

PROPERTIES

Suitable for all position welding. Can be finished by machining with carbide tools. Strongly resists deformation and wear at elevated temperatures. Weld metal has excellent slag detach ability, smooth and shining bead appearance.

PROCEDURE

Clean the weld surface thoroughly. Remove all fatigue layer, sharp corners and edges. Preheat the job to 250-350°C and maintain inter - pass temperature below 200°C. Chip slag between passes. Post heat the job to 450°C and cool slowly to room temperature.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	3.2x350	90-120
	4.0x350	110-140
	5.0x350	160-190

TYPICAL APPLICATIONS

Forging dies for filling all types of die impressions or cavities. Joining and buildup on all drop-forging tools such as punches, dies, inserts, etc. Repair of damaged or worn out profiles. Salvage of scrapped / undersized die blocks by rebuilding totally with weld metal.



SPECIFICATIONS

ALLOY BASIS: Mn, Cr, Ni



TECHNICAL DATA

Hardness 38-42 HRC