



D&H 9650

CHARACTERISTICS AND APPLICATIONS :

A specially developed AC or DC(+) electrode to produce extra high performance weld metal. Superior operating characteristics. Deposit sound weld metal reaching maximum hardness as deposited. Weld metal highly resistant to heat, corrosion and wear with the shock resistance necessary for forging dies. Ideal for reclamation of forging die, hot working tools impressions, reducers guides-ways, flat dies, etc. Also excellent for a tough build-up when a higher hardness material is required on the surface.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Ni	Cr	Mo	V	W
Percent	: 0.13	1.0	0.60	2.02	10.25	2.75	0.35	0.20

WELD METAL HARDNESS (on 3LAYERS) afterSR 560°Cfor one hour:38-43RC

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm)	:	6.3x450	5x350	4x350	3.15x350
Dia x Length					
Current Range (Amps)	:	250-300	180-225	125-175	80-125
Weight/Carton (kgs)	:	5	5	5	5

PRECAUTIONS:

1. Remove all the material by scarfing or grinding.
2. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
3. Use the preheat required for the base material.
4. A carefully designed welding procedure with proper preheat, peening, cleaning, interpass temperature and PWHT will yield the desired results.