



LoTherme GS-9580



Die rebuilding & surfacing flux cored wire

CODIFICATION :

CHARACTERISTICS :



A customized gas shielded flux cored wire designed for fabrication of a new die and re-building of worn-out hot forging dies. The wire has very good welder's appeal and easy slag detachability. The deposited weld metal is tough for hot or cold work tooling. It is free from cracks, porosities and any other surface defects.

SHIELDING GAS:

Co₂ gas
Argon-CO₂ gas mixture

APPLICATION :

LOTHERME GS-9580 wire is suitable for trimmers, shear, blanking & forming dies, punches, header dies, forging dies, hot working tools & guides, etc.

WELDING POLARITY:

DCEP/ DCRP/ DC (+)

TYPICAL ALL-WELD METAL COMPOSITION WITH AR-CO₂ SHIELDING

Element	C	Mn	Si	S	P	Cr	Ni	Mo	V	W
Typical	0.38	1.47	0.82	0.014	0.019	5.4	0.67	1.84	0.28	1.9

ALL-WELD METAL HARDNESS

On a 3-layer deposit in as-weld condition
55-57 HRC

WELDING CURRENT & STICK OUT

Wire diameter, mm	Current, amp	Voltage, V	Stick out, mm
2.4	200 - 300	26 - 30	30 - 40
2.8	250 - 350	26 - 30	30 - 40

PACKING:

Standard size: 2.4mm and 2.8mm

Quantity: The wire is supplied in a layer wound 12.5 kg plastic spool. Each spool is sealed in polythene bag and then packed in a shrink-wrapped corrugated box.



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