

GOLD 1015-E

FOR TOOL AND DIE REPAIR

Description and Applications:

Special economic hard facing electrode with a medium hard machinable deposit.

Crack resistant, high temperature oxidation resistance,
Especially for rebuilding edges of cutting tools , knives, shear blades, drills, punching dies, press tools, forging hammers, and other parts subjected to **metal to metal wear** up to 550 C

Weld metal composition: C-Cr-Mo-martensitic.

Industries: Automotive, engineering, recycling, steelworks, repair shops, Forging shops, sugar mills, cast iron roller.....

Suitable for steels such as SKT-4, SKD-41, SKD 61 etc,.....

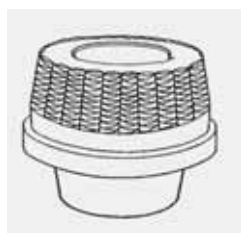
Weld metal deposit: Tungsten, chrome, vanadium



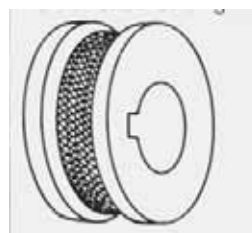
Repair and build up forging tools, dies press tools



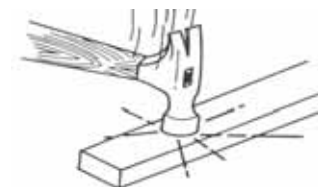
Repair or manufacture shear blades



Punching dies



Rollers



High impact resistance

Mechanical characteristics :

**Hardness
As welded**

45 – 50 HRC

Pakaging Data

Sizes	2.5x350	3.2x350	4x450
Kgs/Packet	4	4.5	4,5
Packets/carton	4	4	4
Kgs/carton	16	16	18

Welding instructions	Current (A)	90	115	160
----------------------	-------------	----	-----	-----



= +,- ~ 70V

Clean area to be over laid.

Preheat according to base metal. Select recommended amperage. For crack sensitive applications use gold 330 as a first layer. Deposit electrode with stringer beads and use short arc, avoid excessive weaving. Ensure that each weld overlaps the previous weld. Remove slag from each weld bead before applying next bead. Deposit a minimum of two layer for best results. Recommended inter pass temperature is from 430-520 C. Allow to cool slowly.