GOLD MAINTENANCE ALLOYS

Anti-wear protection
Heat/corrosion/impact

GOLD 1018-E FOR METAL/METAL WEAR

Description and Applications:

Electrode with a **Co-Cr composition alloyed with Molybdenum** for surfacing of parts which are subjected to a combination of metal/metal wear, corrosion and heat **up to 650 °C** and shortly up to 1000°C.
Especially for rebuilding edges of cutting tools , knives, shear blades, drills, punching dies, press tools, …….

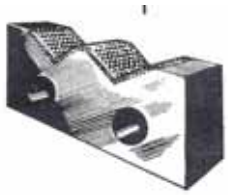
- exceptional resistance to thermal shocks
- deposits are free from cracks or porosity
- **high hot hardness values**
- machinable with tungsten carbide tipped tools

Hot work tools and dies

For high temperature

For entry/exit guides

For driving or idler rolls



shear blades /knives

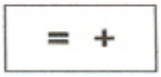
Mechanical properties

Hardness :	**45to 50 HRC at 20 C** **55 HRC after work hardening**

Packaging Data

Sizes	2.5x300	3.2x350	4.0x450
Kgs/Packet	4	4,5	4,5
Packets/carton	4	4	4
Kgs/carton	16	18	18

Welding instructions	**Current (A)**	60-90	90-120	110-150



Clean area to be over laid. Remove old hard facing and fatigue metal by gouging with gold 110 and grinding. Preheat according to base metal. Select recommended amperage and use DC reverse polarity. Hold the electrode vertical.
Deposit electrode with stringer or weaving beads and use short arc, avoid excessive weaving.
On hard steels apply buffer layer of 330 or 510. on cast iron use buffer layer of gold 420 . On low carbon steel Gold 1018 can be applied direct.