

EXCEL FORGE 013 S



TYPICAL APPLICATION

Basic coated low Hydrogen electrode for high temperature resistance surfacing on hot work steels exposed to Compression and abrasion. Application includes tongs slides hot shear blades extrusion pistons, dies strippers steel punching tools, trimmer dies.

PRODUCT FEATURES

1. High hardness accompanied with good toughness.
2. High toughness & heat resistant up to 500°C
3. High resistance to impact, compression, abrasion.
4. Flat, even flow, & easy slag removal.

RECOMMENDATIONS

Build ups, worn out or cracked hot forging dies. Buffer layer of Excel forge 015 is recommended. Suitable for repairing hot forging dies, H-13 material. It is mandatory to use proper preheating & post heating procedure recommended for welding when used for tool steel of any type. Can be used for welding trim edge of hammer & press dies.

PROCEDURE

Pre-heat work piece up to 400°C. Hold electrode as vertical as possible and with a short arc. Allow work piece to cool down slowly. Re-dry electrodes for 2hr at 300°C prior to use

RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
4.00	120-170
3.15	90-120

TECHNICAL DATA

1. Current: AC/DC +
2. Hardness: 55 - 60 HRC

Mfd. By EXCEL CRAFT PVT. LTD. (WELDING DIVISION)

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