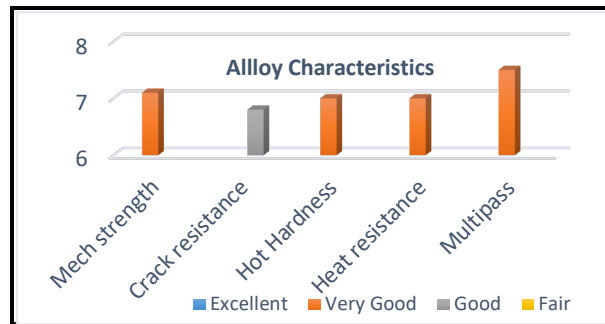


# EXCEL FORGE 014 HMR



## TYPICAL APPLICATION

Designed for its high hardness & high temperature resistance well suited for surfacing on machine components and tools exposed to severe impact, compressive load conditions and abrasion at operating temperature up to 400°C such as tongs slides hot shear blades extrusion pistons, dies strippers steel punching tools. **Specially made for hammer dies.**

## PRODUCT FEATURES

1. Basic coated contact type of electrode.
2. High resistance to abrasive wear, impact, and compressive load conditions.
3. Moderate toughness & high heat resistant up to 400°C
4. Flat, even flow, & easy slag removal.

## RECOMMENDATIONS

Build ups, worn out or cracked hot forging dies. Specially designed for repairing hammer dies. It is mandatory to use proper preheating & post heating procedure recommended for welding when used for DIN 1.2714 or DIN material of equal grade.

## PROCEDURE

Clean metal surfaces. Use "Excel Gouge" to remove damaged metal. 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 250°C prior to use

## RECOMMENDED AMPERAGES

SIZE (mm)	AMPERAGE
5.00	220– 250
4.00	130 – 170
3.15	90– 130

## TECHNICAL DATA

1. Current: AC/DC +
2. Hardness: 45 – 50 HRC

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