

WEARtig Tool 58 (UTP A 673)

Wire for wear-resistant surfacings
on cold and hot working tools

Classifications																	
Material-no.		DIN 8555			EN 14700												
1.2606		WSG 3-60-T			S Z Fe3												
Characteristics and field of use																	
<p>WEARtig Tool 58 is used for the repair and production of hot working tools, such as die cast moulds, forging dies, hot cutting knives, hot-shear blades, axial rolls, roll mandrils, upset plates as well as for the production of working surfaces on non- or low-alloyed base materials.</p> <p>Machining is possible with tungsten carbide tools.</p> <p>Hardness of the pure weld deposit:</p> <table border="0"> <tr> <td>untreated</td> <td>53 - 58 HRC</td> </tr> <tr> <td>soft-annealed 820° C</td> <td>approx. 230 HB</td> </tr> <tr> <td>hardened 1050° C/oil</td> <td>approx. 53 – 58 HRC</td> </tr> <tr> <td>tempered 600° C</td> <td>approx. 53 HRC</td> </tr> <tr> <td>1 layer on non-alloyed steel</td> <td>approx. 45 HRC</td> </tr> </table>								untreated	53 - 58 HRC	soft-annealed 820° C	approx. 230 HB	hardened 1050° C/oil	approx. 53 – 58 HRC	tempered 600° C	approx. 53 HRC	1 layer on non-alloyed steel	approx. 45 HRC
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Typical analysis in %																	
C	Si	Mn	Cr	Mo	V	W	Fe										
0.35	1.0	0.4	5.0	1.5	0.3	1.3	balance										
Welding instruction																	
<p>Clean welding area to metallic bright. Cracks in the base material have to be completely gouged out. Pre-heating temperature of 400°C should be maintained on tools. Stress relief, if necessary, at 550°C. Slow cooling-down.</p>																	
Rod diameter x length [mm]		Current type			Shielding gas (EN ISO 14175)												
1.6 x 1000		DC (-)			I 1												
2.4 x 1000		DC (-)			I 1												
3.2 x 1000		DC (-)			I 1												