

Classifications

EN 14700	DIN 8555
E Fe3	E 3-UM-45-T

Characteristics and typical fields of application

WEARstick Tool 45 is, due to its high strength, toughness and heat resistance ideally suited for buildups on parts subject to friction, compression and impact at elevated temperatures, such as hot shears blades, gate shear, forging saddles, hammers, forging dies, Al-die cast moulds. WEARstick Tool 45 is also used to good advantage for the production of new cold and hot working tools with low-alloy base materials.

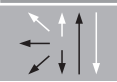
The stick electrode has excellent welding properties, a stable and regular flow, good bead appearance and very easy slag removal. Heat resistant up to 550 °C.

Hardness of the pure weld metal: approx. 45 – 50 HRC

Typical analysis

	C	Si	Mn	Cr	Mo	Fe
wt.-%	0.2	0.5	0.6	5.0	4.0	Bal.

Operating data

	Polarity	DC + / AC	Dimension mm	Current A
	Redrying	300°C / 2h	2.5 × 300	60 – 90
		3.2 × 350	80 – 100	
		4.0 × 400	100 – 140	
		5.0 × 400 *	130 – 170	

* available on request

Preheat the workpiece to 400 °C. Hold stick electrode as vertically as possible and with a short arc. Take care of a slow cooling of the workpiece. Finishing by grinding or hard metal alloys.

Approvals

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