

Classifications

EN 14700	DIN 8555
E Z Fe3	E 3-UM-40-PT

Characteristics and typical fields of application

WEARstick Tool 40 is, due to its toughness and heat resistance, ideally suited for surfacings on parts and tools subject to abrasion, compression and impact at elevated temperatures. Particularly for buildups on forging dies, die cast moulds, rollers, wobbler drives, hot-shear blades. WEARstick Tool 40 also offers an economic solution for the production of new tools, for which a base material with an adequate tensile strength is recommended.

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. 38 – 42 HRC

Typical analysis

	C	Si	Mn	Cr	Mo	Fe
wt.-%	0.1	0.5	0.6	6.5	3.5	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

Welding instructions

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. Machining is possible with tungstene carbide tools.

Approvals

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