

Classifications

EN 14700	DIN 8555
E Z Fe3	E 3-UM-60-ST

Characteristics and typical fields of application

WEARstick Tool 58 is used for wear resistant buildups on cold and hot working tools, particularly for cutting-edges on hot cutting tools, hot-shear blades, trimming tools and cold cutting knives. The production of new cutting tools by welding on non-alloy or low-alloy base materials is also possible.

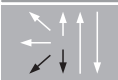
WEARstick Tool 58 has excellent welding properties, a homogeneous, finely rippled bead appearance due to the spray arc and very easy slag removal. This stick electrode is weldable with very low amperage settings (advantage for edge buildup). Heat resistant up to 550 °C.

Hardness of the pure weld metal: approx. 58 HRC

Typical analysis

	C	Si	Mn	Cr	Mo	W	V	Fe
wt.-%	0.3	0.8	0.4	5.0	1.5	1.3	0.3	bal.

Operating data

	Polarity	DC + / DC - / AC	Dimension mm	Current A
	Redrying	300°C / 2h	2.0 x 300*	30 – 50
			2.5 x 300	50 – 70
			3.2 x 350	90 – 120
			4.0 x 400	130 – 160

* available on request

Welding instructions

Preheat high-alloy tool steels to 400 – 450 °C and maintain this temperature during the whole welding process. Hold stick electrode vertically with a short arc and lowest possible amperage setting. Machining only by grinding.

Approvals

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