

## Classifications

<b>EN 14700</b>	<b>DIN 8555</b>	<b>AWS A5.13 / SFA-5.13</b>
E Fe4	E 4-UM-60-ST	EFe5-B (mod.)

## Characteristics and typical fields of application

WEARstick Tool 60 is used for repair and production of cutting tools, particularly for building-up cutting edges and working surfaces. The deposit is highly resistant to friction, compression and impact, also at elevated temperatures up to 550 °C. The production of new tools by welding on non-alloy and low-alloy base metals is also possible (cladding of cutting edges).

WEARstick Tool 60 has excellent welding properties, a smooth, finely rippled bead appearance and very easy slag removal due to the rutile coating. The weld deposit is equivalent to a high speed steel with increased Mo-content.

Hardness of the pure weld metal: approx. 62 HRC  
 soft annealed 800 – 840 °C: approx. 25 HRC  
 hardened 1180 – 1240 °C and  
 tempered 2 x 550 °C: approx. 64 – 66 HRC

## Typical analysis

	C	Si	Mn	Cr	Mo	W	V	Fe
wt.-%	0.9	0.8	0.5	4.5	8.0	2.0	1.2	bal.

## Operating data

	<b>Polarity</b>	DC + / AC	<b>Dimension mm</b>	<b>Current A</b>
	<b>Redrying</b>	300°C / 2h	2.5 × 350	70 – 90
			3.2 × 350	90 – 110
			4.0 × 450	110 – 130

## Welding instructions

Clean the welding area and preheat high-speed steel tools to 400 – 600 °C, maintain this temperature during the whole welding process, followed by slow cooling. Machining by grinding is possible. Hold stick electrode vertically and with a short arc.

## Approvals

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