

**Electrode for Metal-to-Metal Wear Resisting and Anti Erosion (TIG Welding)**

**M H - 1 1 5 T**

■ Standard                      AWS (RFe5-A)

■ Tip Color                      White

■ Application

Overlaying for punching mold, mold for cold forging, cutting tool, shear, mold for hot forging, hot extrusion die and etc.

■ Features

1. MH-115T is TIG welding electrode which corresponds to high-speed tool steel, SKH51. It shows excellent metal-to-metal impact wear resistance at normal and high temperature.
2. The deposited metal show high hardness and impact resistance as welded. By tempering process at 550°C after welding, the deposited metal becomes much harder. Also its toughness is improved.

■ Welding Procedures

1. Keep 250~350°C preheating and interpass temperature. After welding, slow cooling is required for preventing crack. Excessive preheating increases the risk of crack rather.

■ Typical Chemical Components of the Electrode (%)

C	Si	Mn	Cr	Mo	V	W
0.80~0.90	≤0.40	≤0.40	3.80~4.50	4.50~5.50	1.60~2.20	5.50~6.70

■ Typical Hardness of the Deposited Metal

Conditions	HV	HRC	HS
As Welded	650~740	58~62	78~84
550°Cx1hr Tempering	800~900	64~67	88~95

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity (Kg)
1.6 2.0 2.5 3.2 4.0	1,000	5

Equivalent to electrode for shielded metal arc welding: GRIDUR36