

Covered Electrode on Flame-Hardening Steel

M H - 5

- Standard —
- Covering Low Hydrogen Type
- Tip Color Blue

■ Application

MH-5 is suitable for modifying cutting blade or repair overlaying of cold pressing mold which is made by flame-hardening steel such as HMD and ICD.

MH-5 can use on the mold for hot forging and die face of the drawing die.

■ Feature

1. MH-5 is the covered electrode for cold pressing mold which is made by flame-hardening steel.
2. The deposited metal of MH-5 is designed to become same chemical component with HMD,ICD or OKS
3. Hardness of the deposited metal is about HRC57
4. MH-5 shows excellent welding performance and crack resistance. Also, its hardness is very stable.

■ Welding Procedure

1. For stabilize hardness, preheating about 200°C before welding is suggested.
2. The electrode should be re-dried 30~60 minutes at over 300°C before use.

■ Typical Chemical Component of the Deposited Metal (%)

C	Si	Man	Cr	Mo	Fe
0.51	0.72	0.86	1.54	0.14	Remain

■ Typical Hardness of the Deposited Metal as welded

HV	HRC	HS
580~670	54~59	72~80

■ Appropriate Welding Current (AC or DCEP)

Diameter (mm)	2.6	3.2	4.0
Length (mm)	300	350	350
Current (A)	60~90	70~110	100~150
Minimum Quantity (Kg)	3.0	5.0	5.0

Equivalent to wire for MAG welding: MH-5S
 Equivalent to electrode for TIG welding: MH-5T