

Electrode for Overlaying on Various Kinds of Molds (TIG Welding)

M H - 5 T

■ Tip Color Blue

■ Application

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

Repair overlaying for SKS, SK, SUJ, and so on.

■ Features

1. MH-5T is TIG welding electrode for hardfacing on cold pressing mold which is made by flame-hardening steel.
2. The deposited metal of MH-5T is designed to become same chemical component as the base metal made by HMD, ICD.

■ Welding Procedures

1. Preheating at over 250°C and slow cooling is required.
2. In case of welding cutting blade, avoid over penetration at starting point.
3. To prevent crack during heat treatment, be careful not to cause undercut at welded zone.

■ Typical Chemical Components of the Electrode (%)

C	Si	Mn	Cr	Mo
0.4~0.7	0.7~1.3	0.7~1.2	0.8~1.2	≤0.30

■ Typical Hardness of the Deposited Metal

Conditions	HV	HRC	HS
As Welded	670~750	59~62	79~85
850°C Oil Hardening→200°C Tempering	710~740	60~62	82~84
850°Cx1h→Furnace Cooling	260~290	24~29	37~41

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity(Kg)
1.2 1.6 2.0 2.6	1,000	5

Equivalent to electrode for shielded metal arc welding: MH-5

Equivalent to wire for MAG welding: MH-5S