

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

M H P - 1 3 T

■ Tip Color Yellow

■ Application

Overlaying on the mold for corrosion resistant plastic such as PD555 and HPM38, blanking mold and press mold. Hardfacing for forming roll, valve, shear and punch.

■ Features

1. MHP-13T is TIG welding electrode for hardfacing. The deposited metal is martensite structure, which is high-carbon 13%Cr steel type. Also the deposited metal has strong self hardening property. As a result, the hardness of the deposited metal exceeds HV500 as welded.
2. The deposited metal has good heat, corrosion and wear resistance.

■ Welding Procedures

1. Preheating and interpass temperature require more than 200°C

■ Typical Chemical Components of the Electrode (%)

C	Si	Mn	Ni	Cr
0.32	0.35	0.35	0.20	12.5

■ Typical Hardness of the Deposited Metal

Conditions	HV	HRC	HS
As Welded	500~560	49~53	66~70
600°C*2h→Furnace Cooling	330~350	33~36	46~50

■ Dimensions

Diameter (mm)	Length (mm)	Minimum Quantity(Kg)
1.2 1.6 2.0 2.4 3.2 4.0	1,000	5

Equivalent to electrode for shielded metal arc welding: KT-11CR
 Equivalent to wire for MAG welding: MH-13HS