

Electrode for Direct Hardfacing on Cast Iron (TIG Welding)

O M H - 1 T

- **Tip Color** Yellow

- **Application**

Super hardfacing of press mold and overlaying and repairing of shearing blade used for hot and cold processing.

- **Feature**
 1. OMH-1 is the electrode for TIG welding. OMH-1T achieves direct hardfacing and edge preparation on the mold which is made by various kinds of cast iron such as FC and FCD.
 2. As welded, the weld metal on the cast iron base metal shows about HRC55 stably by two layers welding.
OMH-1T is also suitable for repairing edge preparation.

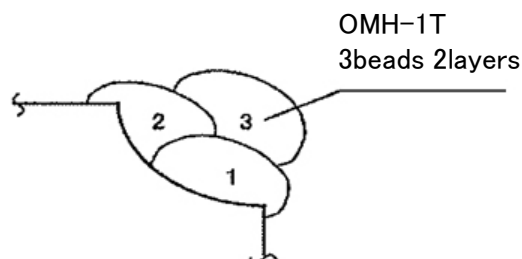
- **Welding Procedure**
 1. To minimize the dilution of the base metal, welding current should keep low.

- **Typical Chemical Components of the Electrode (%)**

C-Si-Mn-Special Elements

- **Typical Hardness of the Weld Metal (Triple pass two layers on FC300)**

	Hardness of the Edge
As Welded	more than HRC55



- **Dimension**

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

Equivalent to electrode for shielded metal arc welding: MH-1
 Equivalent to wire for MAG welding: OMH-1