



D&H 953

CHARACTERISTICS AND APPLICATIONS :

A specially designed electrode for nitrided dies. Superior operating characteristics in all conventional positions. Deposit sound weld metal, reaching hardness as deposited. Weld metal of radiographic quality.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P	Cr	Ni	Mo
Percent	: 0.08	0.55	0.40	0.018	0.025	10.0	5.0	3.0

WELD METAL HARNESS : 42-48 RC

CURRENT AND PACKING DATA: AC / DC (+)

Size (mm)	: 6.3x450	5x450	4x350	3.15x350
Dia x Length				
Current Range (Amps)	: 250-300	180-225	125-175	80-125
Weight/Carton (kgs)	: 4	4	4	4

PRECAUTIONS:

1. Re bake the moisture electrodes at 250-300°C for 1 hr.
2. For repairs prepare area to be welded by removing all cracks, heat checks or other defects by grinding or scarfing.
3. Preheat the die blocks up to 425°C and maintain temperature during welding.
4. Use stringer bead technique.
5. Peen the weld when hot to relieve stresses.