

Classifications

Material-no.	DIN 8555	EN 14700
1.2606	WSG 3-60-T	S Z Fe3

Characteristics and field of use

WEARtig Tool 58 is used for the repair and production of hot working tools, such as die cast moulds, forging dies, hot cutting knives, hot-shear blades, axial rolls, roll mandrils, upset plates as well as for the production of working surfaces on non- or low-alloyed base materials.

Machining is possible with tungsten carbide tools.

Hardness of the pure weld deposit:

untreated	53 - 58 HRC
soft-annealed 820° C	approx. 230 HB
hardened 1050° C/oil	approx. 53 – 58 HRC
tempered 600° C	approx. 53 HRC
1 layer on non-alloyed steel	approx. 45 HRC

Typical analysis in %

C	Si	Mn	Cr	Mo	V	W	Fe
0.35	1.0	0.4	5.0	1.5	0.3	1.3	balance

Welding instruction

Clean welding area to metallic bright. Cracks in the base material have to be completely gouged out. Pre-heating temperature of 400°C should be maintained on tools. Stress relief, if necessary, at 550°C. Slow cooling-down.

Rod diameter x length [mm]	Current type	Shielding gas (EN ISO 14175)
1.6 x 1000	DC (-)	I 1
2.4 x 1000	DC (-)	I 1
3.2 x 1000	DC (-)	I 1