

Standards	Werkstoff No.	1.6356
	DIN 8555	E4-UM-350-CKPSTZ

Characteristics Tubular wire electrode for hardfacing and repair of die steels. Specifically huge volume pressing tools with particular reference to H 13 and mar aging steels. The deposits are easy machinable and heat treatable where improved hardness is required.

Typical applications Facing of dies, stamping tools, metal drawing tools, pressure die casting tools.
The resultant weld metal deposits give improved edge hardness to cold cutting tools and shears.

Working temperature 20°C up to 450° C

Hardness of all-weld metal (typical values)	as welded	soft annealed / 4 h at 480°C
	ca. 350	ca. 55 HRc

Weld metal analysis (typical, wt. %)	C	Si	Ni	Mo	Co	Ti
	0,03	0,3	18	4	12	+

Gas types EN 439 M13: 99% Argon with 1% Oxygen **Current = +**

Current intensity	DIA (mm)	DIA (inch)	Volt	Amps	Delivering form
	1,2	3/64	19 - 22	120 - 220	G
	1,6	1/16	20 - 26	160 - 260	G
	2,0	5/64	22 - 27	220 - 280	G
	2,4	3/32	24 - 28	260 - 340	G
	2,8	7/64			
	3,2	1 / 8			

Delivering form
O = Flux cored wire self shielding
G = Flux cored wire for shielded arc welding
S = Flux cored wire for submerged arc welding

Coils, weight B/BS 300 = 15 kg B 450 = 30 kg pay off pack = 150 / 300 kg
Rev. 000