

## GTAW (TIG) WELDING RODS FOR TOOL & DIE REPAIR (3) MAINTENANCE -HARDFACING

PRODUCT CODE GOLD	DESCRIPTIONS/ APPLICATION	TECHNICAL DETAILS	SIZE Ø mm
330 T	<b>Multipurpose high strength</b> TIG (GTAW) filler wire for welding alloy and high-alloy-steels, cold working tool-steels, stainless steels, difficult to weld and dissimilar steel welding. (SKD11,SKD61) Use for buffer layer before hard facing . Weld SUS 304,SUS 420 , repair shafts, piston rods etc. CLASSIFICATION : ISO 14343 A W 29 9	Tensile strength: <b>730 Rm (MPa)</b> Hardness as welded <b>HB 200-210</b> Work hardens to <b>HB 400-450</b>	1.6 2.4
420 T	<b>High strength Fe Ni Alloy</b> for welding on cast iron and joining cast iron to steel. For repairs on glass and press molds ,engine and cylinder blocks .....	<b>Hardness: 130-160 HB</b> Material 2.4560	2.4
728 T	<b>For repairs and overlays on Aluminium-die casting</b> and plastic injection moulds ,cold and hot working dies (SKD11,H13 ) Boehler K110Stavax ESR . For welding maraging steel 200-500,Deposit can be machined and age hardened at 480 C to 50 HRC	<b>Hardness: HRC 34-36</b> as welded Material No. ~1.6356	1.0 1.6 2.5
1015 T	For <b>tool and die repair</b> . Deposits are machinable. High impact resistance and toughness. Use for trimming tools, hot and cold cutting dies shear blades, etc.	<b>Hardness (HRC) 41-46</b> Mat. No. 1.2567	1.6 2.4
7201 T	<b>For repair and build ups on tools and dies</b> subject to high impact and medium abrasion. Can be used for overlays on case and air hardening steels, Nitriding steels(1.8519,1.8521,1855) and cast iron Excellent cutting ability.	<b>Hardness: HRC58-60</b> Mat. No.1.4718 Alloy: Fe, Cr Si.Ni C	1.6 2.4
1045 T (Co 6)	Cobalt based Rod for surfacing of parts which are subjected to a combination of metal/metal wear, corrosion and heat up to <b>650 °C</b> and shortly up to 1000°C.Especially for rebuilding edges of Valve seats, cutting tools , knives, shear blades, drills, punching dies, press etc.Excellent hot hardness.	<b>Hardness: 39-43HRC</b> Co Cr,W,Ni,Fe, WSG-20-GO-40CTZ	3.2
1047 T (Co 12)	Cobalt base rods with high impact resistance specially develop for hardfacing of hot working and wood cutting tools. Alloy: Ni, Cr, Mo, Co, WC, Fe	<b>Hardness: HRC 34 at 400 °C</b> EN 14700 S Co2	3.2
1049 T (Co 21)	High cobalt and chrome alloy. For building up engine valve and valve seats , gas turbines, furnace parts, heat treating baskets, cams , hot trimming ,drop forging hammers & dies, mixers for chemical processing, extrusion nozzles, press tools.	<b>Hardness: 28-34 HRC</b> <b>~ 20 HRC at 400 °C</b> AWS A5.21 ERCoCr-E	3.2



**BALL VALVE :  
HARDFACING WITH 1047 T**



**ALUMINIUM DIE CAST MOLD  
REPAIR WITH GOLD 728 /1015 T**



**FORGING DIE:  
REPAIR WITH 1049 T**