



MODI DIEHARD

SPECIAL HARD SURFACING ELECTRODE

CHARACTERISTICS : A special purpose hardfacing electrode with controlled hydrogen which gives a deposit of low alloy steel in the weldmetal. The weldmetal displays excellent resistance to heat and retains hardness at elevated temperatures. The weldmetal has high resistance to cracking.

APPLICATIONS :

- * Suitable for surfacing hot forging dies.
- * Repairing of hot working tools.

RECOMMENDATIONS : The electrode should be kept dry. In case it has picked-up moisture, it should be re-dried at 200-250°C for one hour. Use stringer bead technique with short arc. Lower current of the recommended range should be used. For surfacing of hardenable materials of large section/ thicknesses, proper preheating and slow cooling is to be adopted. Stress relieving may be carried out as required by the material.

CHEMICAL ANALYSIS OF WELD-METAL (%) :	C	Mn	Si	Cr	Ni
	0.10 max	1.4-1.8	0.3-0.7	2.0-3.0	2.0-2.5
	Mo	V	W		
	1.2-1.8	0.2-0.4	0.8 max		

HARDNESS : (On 2 layers deposit) : 350-400 BHN (As welded)

CURRENT CONDITIONS : USE DC (+) OR AC (70V)

Size (mm)	4.0x450	5.0x450	6.3x450
Current (Amps)	140-180	180-230	230-270



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