

CARBODUR WZ 54 AC

International standards	DIN 8555	E 3-UM-55-T
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Characteristics CARBODUR WZ 54 AC is a rutile electrode with 150 % recovery. It deposits an air hardening and wear resistant alloy. It can be applied to reclaim hot-forging dies and to overlay the edges and flat areas of low alloyed high density steel tools.

Typical applications The electrode is typically applied on: slab shears, hot-forging dies, drawing dies, containers, crushing equipment and depressions created by forging, pressure and impact stress.

Operating temperature ---

Recommendations for welding and heat treatment The preheat and interphase temperatures should be held between 250°C and 300°C depending on the base metal and its heat abduction. Normally, the higher temperature range should be chosen. Heat induction during low tension welding should be continually monitored. Slow cooling is recommended using sand or oven methods.

Mechanical properties of all-weld metal (typical values)	Hardness as welded HRc	Tensile strength R_m N / mm²
	53-56	1800-2050

Weld metal analysis (typical, wt. %)	C	Si	Mn	Cr	Mo
	0,4	0,45	1,4	7,5	2,5

Current = + / ~ , 65 V

Welding positions PA, PB, PC

Rebaking 1 h, 350 °C +/- 10 °C (if required)

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	50 - 70	161	645	31,0	5,0	20,0
3,2 x 350	80 - 110	95	381	52,5	5,0	20,0
4,0 x 350	100 - 130	63	252	79,5	5,0	20,0
5,0 x 450	120 - 160	31	125	159,7	5,0	20,0