



NIMOTEN HFD

HARD FACING (High Temperature Oxidation - Impact - Abrasion)



Welding Electrode for repair of Forging Dies

ALLOY BASIS :

C, Cr, Ni, Mo, W

KEY FEATURES :

- Heavy coated electrode
- Weld deposit with excellent toughness and hardness properties
- Superior metal to metal wear resistance at high temperatures
- Multipass crack free weld deposit maximum up to 15 mm

WELDING POSITION :



AC (90 V) / DCEP

TYPICAL APPLICATIONS :

- For repair of large hot working dies, press forging dies
- Hot piercing punches, Impactor dies, Screw press dies
- Parts of earth moving equipment
- Forming dies, Trimming dies, Blanking dies
- For H series tool steels such as H11, H12, H13

REDRYING CONDITION : 300°C for 1 hr.

PHYSICAL PROPERTIES :

Condition	Hardness, 3 Layer HRc
As Welded	50 – 54

Machinability



Abrasion Resistance



Impact Resistance



Corrosion Resistance



PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Approx. Pcs/Carton	Carton/Box	Approx. wt. of 1000 pcs, Kg.
4.0 x 450	140-180	71	4	71
5.0 x 450	190-230	45	4	111
6.3 x 450	260-320	29	4	174

Physical Properties: With increase in number of squares, property improves