



MCAW (Hard facing)  
**AUTOMIG MC 40**

GAS SHIELDED METAL CORED WIRE FOR RECLAMATION OF HOT FORGING DIES



**ALLOY BASIS :**

Cr, Mo, Ni, V

**KEY FEATURES :**

- Gas shielded metal cored wire
- Low alloy steel weld deposit
- Stable and smooth arc, no spatter
- No slag, smooth weld bead
- Weld deposit free from porosity
- Excellent resistance to metal to metal wear at high temperatures and thermal shocks
- Suitable for multi-pass crack free welding

**WELDING POSITION :**



**DCEP**

Shielding Gas	Gas Flow Rate, LPM	Stickout, mm
80Ar+20CO <sub>2</sub>	18-25	15-30

**TYPICAL APPLICATIONS :**

- For surfacing and reclamation of large hot working dies specially drop and press forging dies, hot working tools
- Suitable for H11, H13, DIN 1.2714 and DB-6 die block material

**STORAGE / HANDLING :**

Keep dry and follow handling instructions mentioned on the box

**PHYSICAL PROPERTIES :**

Condition	3 Layer Hardness, HRC
As Welded	39-44
Stress Relieved	40-45

**Machinability**

**Metal to Metal Wear Resistance**

**Impact Resistance**

**Corrosion Resistance**



**PARAMETERS - PACKING DATA :**

Ø, mm	Voltage, V	Amperage, A	Kg/Spool
1.60	26 - 32	260 - 400	12.5
2.00	27 - 34	280 - 450	12.5
2.40	28 - 36	300 - 500	12.5