



MCAW (Hard facing)
AUTOMIG MC 50

GAS SHIELDED METAL CORED WIRE FOR RECLAMATION OF HOT FORGING DIES



ALLOY BASIS :

Cr, Mo, Ni, W, V

KEY FEATURES :

- Gas shielded metal cored wire
- Stable and smooth arc, no spatter
- No slag, smooth weld bead
- Excellent toughness and hardness properties at high temperatures
- Resist metal to metal wear and thermal shocks
- Weld deposit free from porosity
- Multi-pass crack free weld maximum up to 15 mm

WELDING POSITION :



DCEP

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

TYPICAL APPLICATIONS :

- For surfacing and reclamation of large hot working dies, press forging dies hot working tools
- Hot piercing punches, Impactor dies, Screw press dies
- Forming dies, Trimming dies, Blanking dies
- Suitable for H11, H13, DIN 1.2714 and DB-6 die block material
- Parts of earth moving equipment

STORAGE / HANDLING :

Keep dry and follow handling instructions mentioned on the box

PHYSICAL PROPERTIES :

Condition	3 Layer Hardness, HRc
As Welded	48-52
Stress Relieved	49-54

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