

CARBODUR WZ 50 AC

International standards

DIN 8555	E 3-UM-50-T
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Approvals ---

Typical applications and characteristics AC-weldable high-quality electrode with approx. 120 % recovery. Used for repairing steels of same type, e.g. on hot working tools, and for overlaying edges or surfaces of tools made of low alloyed high density steels. Typical applications: slab shears, hot shear blades, drawing blocks, hot-forging dies, impact moulding dies, containers, swages etc.

Operating temperature ---

Base materials

1.2365 G-X 32 CrMoV 3 3	1.2713 G 55 NiCrMoV 6
1.2567 30 WCrV 17-2	1.2714 GS 56 NiCrMoV 7
1.2581 X 30 WCrV 9-3	

Recommendations for welding and heat treatment Preheating- and interpass temperature should be held between 300 and 450°C, depending on the base metal and its heat abduction. The upper temperature limit should be chosen for thick work pieces. Low-tension welding and low heat input are essential for a good welding result.. Slowly cool down in sand or oven.

Mechanical properties of all-weld metal

	Hardness HRc as welded	Hardness HRc after heat treated at 560° C	Hardness HRc after h.t. at 450° C	Hardness HRc after h.t. at 350° C	Hardness HB soft annealed 2 h at 800-840°C
(typical values)	approx 47	approx. 52	approx. 49	approx. 48	approx. 250

Weld metal analysis (typical, wt. %)

C	Cr	W	V
0,3	2,2	4,2	0,6

Current = + / ~ 65 V

Welding positions PA, PB, PC, PD, PE, PF

Rebaking 1 h, 300 °C + / - 10 °C (if required)

Flux-cored wire equivalent

CARBO F- WZ 50

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	60 - 80	227	909	22,0	5,0	20,0
3,2 x 350	80 - 120	135	539	37,1	5,0	20,0
4,0 x 350	110 - 150	89	356	56,2	5,0	20,0
5,0 x 450	140 - 180	53	213	11,.9	6,0	24,0