

# GEMET 3715



## DESCRIPTION :

Basic coated, low hydrogen electrode depositing weld metal which is well suited for highly abrasion resistance application. The weld deposit is high quality tool steel which is tough, hard, wear and oxidation resistance.

## ALLOY BASIS

Mo, Cr, W, V, C

## TYPICAL USES :

For manufacturing new cold & hot working tools, hot cutting tools, trimming knives, cold punching tools, valves, extrusion press pistons, forging tools.

**HARDNESS OF THE PURE WELD :** As welded 59 - 62 Rc

**METAL AFTER WORK HARDENING :** 62 - 65 Rc

## WELDING INSTRUCTIONS :

- Redry electrodes at 300oC / 2 hrs. before use.
- Preheat the workpiece to about 400°C
- Hold electrode as vertically as possible and with a short arc, deposit welds. Allow the workpiece to cool slowly.
- Finish by grinding

## HEAT TREATMENT INFORMATION :

**ANNEALING :** 4 hours at 820°C

**HARDENING :** 1180 - 1230oC quenching in oil

**TEMPERING :** 540 - 560°C

**WELDING CURRENT :** AC / DC (+)

## RECOMMENDED CURRENT AND PACKING DATA

SIZE (mm)	LENGTH (mm)	AMPS AC/DC(+)	PACKING PER BOX, KG
3.15	350	80-110	2 x 5= 10
4.00	350	110-140	2 x 5= 10
5.00	350	150-200	2 x 5= 10