

GRIDUR TLK



IDENTIFICATION : GRIDUR TLK

CLASSIFICATION : AWS/SFA 5.13 : EFe5 -B DIN 8555 : E4 - UM - 60-ST

DESCRIPTIONS :

Basic coated electrode depositing molybdenum alloyed high speed steel with hot hardness (upto 6000C) coupled with toughness and crack resistance. New tools can be manufactured by overlaying mild or alloyed steel blanks, annealing to facilitate machining, quenching and tempering to give required hardness.

TYPICAL APPLICATIONS :

- Cutting and pearcing tools
- Dies and drills
- Ingot tongs
- Blanking dies, shear blades, milling tools rolling mill guides etc.

WELD METAL ANALYSIS (RANGE) % :

| C | Mn | Si | Cr | Mo | V | W |
|-----------|-----------|-----------|---------|---------|----------|----------|
| 0.50-0.90 | 0.30-0.60 | 0.25-.070 | 3.0-5.0 | 7.0-9.5 | 0.8-1.30 | 1.0-2.50 |

HARDNESS AS WELDED : 59-63 Rc

Annealed 8000c/furnace, slow cool : 25z Rc Max

Temper 5500c/2 hrs/aircool : 60-65 Rc

CURRENT CONDITION AND PACKING SPECIFICATION :

| SIZE (mm) | LENGTH (mm) | CURRENT RANGE DC (+) AMPS | PACKING SPECIFICATION Kg. |
|-----------|-------------|---------------------------|---------------------------|
| 2.5 | 350 | 70-115 | 2X5=10 |
| 3.15 | 350 | 90-155 | 2X5=10 |
| 4.0 | 350 | 130-210 | 2X5=10 |