

CARBODUR WZ 48 B

International standards

DIN 8555	E 3-UM-45-T
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Characteristics CARBODUR WZ 48 B is a basic electrode suitable on parts subject to friction, compression and impact at elevated temperatures, such as hot shear blades, forging saddles, hammers and forging dies.

Typical applications The electrode is typically applied on: slab shears, hot-forging dies, drawing dies, containers, crushing equipment and depressions created by forging, pressure and impact stress.

Operating temperature ---

Recommendations for welding and heat treatment The preheat temperatures should be held between 400° C depending on the base metal and its heat conduction. Normally, the higher temperature range should be chosen. Heat induction during low tension welding should be continually monitored. Slow cooling is recommended using sand or oven methods.

Mechanical properties of all-weld metal (typical values)

Hardness as welded HRc
45-50

Weld metal analysis (typical, wt. %)

C	Si	Mn	Cr	Mo
0,3	0,5	0,5	5,0	4,0

Current = +

Welding positions PA, PB, PF, PC

Rebaking 1 h, 350 °C + / - 10 °C (if required)

Dia./Length	Amperage (A)	kg / packet	kg / carton
2,5 x 350	60 - 80	5,0	20,0
3,2 x 350	80 - 110	5,0	20,0
4,0 x 350	100 - 140	5,0	20,0
5,0 x 450	130 - 170	6,0	24,0

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