



HH 62 TS WATER HARDENING TOOL STEEL

DC REVERSE OR AC ELECTRODE

General Characteristics

HH 62 TS is an all position, titania coated electrode suitable for welding of water hardening steel grades. Deposits are hard as welded, with a fine grain structure, and are completely heat treatable to facilitate machining and re-hardening to the desired hardness. The deposit of this electrode reaches full hardness in the un-tempered condition.

Procedure.

Clean the welding zone free from oil, rust and other contaminants. Grind out cracks and other defects, and pre-heat water hardening tool steel units from 275° F to 450° F, depending on its size, and maintain temperature during welding. Deposit short stringer beads and peen each deposit rapidly while forgeable. Use the lower preheat when welding small parts that are subject to heat input from the arc. After welding, cool the unit to 150° F in still air and then temper at 450° F at one hour per inch of thickness of unit welded.

Application

This electrode is primarily used for repairing water hardening tools and dies including types W-1 through W-5. Some examples of tools include cold working units such as shears, trimmers, punches, dies, nibblers and other cutting edges. Other application would include cutting and bending tools and deep drawing and drawing tools.

Hardness (RC)

60-64

Alloy Type

Carbon-Silicon-Manganese-Vanadium Type

Heat Treatment

Use W-1 Procedure

Diameter (Inch)	3/32	1/8
(mm)	2.5	3.2

Amps (approx.)	60-90	75-125
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