



**WELTRODE**<sup>®</sup>  
— The Welding Technology

## **Weltrode WC 7100 AC-DC**

**Superior Electrode For All Hot Work Tool Steels Subjected to Heat Checks**

### **Why Do Welders Choose Weltrode WC 7100 AC / DC**

Deposits with Weltrode WC 7100 maintain sharp edges at much higher temperatures . Produce X - ray quality and uniform quality weld deposits in all positions using both AC or DC current . Weld metal maintains properties of H13 Tool Steel.

### **Special Features**

- + Deposit of Weltrode WC 7100 can take sudden thermal shock and impact without cracking
- + High hardness and compressive strength
- + Special fluxing agents produce homogeneous porous free high density weld deposits.
- + Can be used for both hot and cold tooling applications
- + Special metallurgical composition can withstand alternate cooling and heating.



## Applications

For repair and reclamation of Dies subjected to Heat Checks.

Typical Applications on tools and dies under thermal shock caused by extreme thermal cycling

Die cast Molds , Extruding Dies, Forging Dies, Coining Dies

## Typical Properties

Hardness RC 50-52

## International Specification

Proprietary Product

## Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	40	70	100
Maximum Amperage	55	85	110

## Welding Techniques

Clean weld area. When welding on tool steel, preheat the part to 1100F (600C) and maintain this temperature during welding.

Allow parts to cool slowly. Build part to desired shape by using as many passes as necessary. Forge and grind to required dimension. Heat treat and harden as you would for the base metal upon which the weld was applied. Peen to relieve stresses and remove slag