



Weltrode WC 7400 AC-DC

Premium Quality Medium Hardness Alloy For Most Tool Steels

Why Do Welders Choose Weltrode WC 7400 AC / DC

Unique alloy formulation makes this electrode outstanding for the repair of all tool steels. Deposits of Weltrode WC 7400 are highly crack resistant forgeable and temperable. Any number of passes can be made. Furthermore repairs can be made in all positions.

Special Features

- ✦ Deposit of Weltrode WC 7400 are dense and resistant to high abrasion moderate impact and wear
- ✦ High dimensional stability during and after welding heat treatment.
- ✦ Extremely Smooth ,spatter free and turbulence free arc transfer.
- ✦ All position welding possible
- ✦ Self Releasing Slag
- ✦ Excellent Re strike Characterstic enables even an unskilled welder to weld repair without sticking

Typical Properties

Hardness

**RC 45-48 as welded
RC 52-55 work hardened**



Application

Ideal for repair and build up of shearing blades, planer plates anvils woodworking tools, percussion drills, earth borers pressure rollers, clamping tools, worm conveyors, mixer arms rollers shovel and dredger teeth, crusher jaws and rings.

Ideal for machine part of steel, cast steel and manganese steel which are subject to grinding wear combined with strong impact.

Used for the working edges when making composite dies using low cost carbon steels for the base.

Recommended Amperage Settings :

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	55	70	90
Maximum Amperage	75	90	110

Welding Techniques

Clean weld area. In general it is not necessary to preheat but if base metal is highly carbonized it should be preheat to approximately 390°F (200°C). Build part to desired shape by using as many passes as necessary. Heat to bright red color. 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 between passes

Use DC Reverse Polarity