



## **Weltrode WC 7800 AC-DC**

### **Premium Quality Work Hardening Alloy For Most Tool Steels**

#### **Why Do Welders Choose Weltrode WC 7800 AC / DC**

Weltrode WC 7800 is an all position AC/DC coated electrode, for welding A and D series A.I.S.I. Tool steels. The unique formulation enables welding at the lowest amperage with minimum dilution and freedom from porosity and slag inclusions.

#### **Special Features**

- ✦ The deposition of Weltrode WC 7800 shows extremely high abrasion resistance with high hardness
- ✦ Welded deposit has high toughness with excellent crack and impact resistance.
- ✦ Smooth and spatter free operation providing high quality porosity free weld.
- ✦ All position welding possible
- ✦ The unique moisture proof low hydrogen coating assures high shelf life.

#### **Typical Properties**

**Hardness**

**RC 45-48 as welded  
RC 55-58 work hardened**



## Application

Used specially on tools and dies of the 5% chromium type and the high carbon high chromium types.

Typical application Include extrusion dies, blanking dies, coining dies, forming dies, cutting dies, shears and other cutting edges.

An exceptionally good electrode for welding on D2 Air Hardening steel.

## Recommended Amperage Settings :

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	60	80	100
Maximum Amperage	80	100	130

## Welding Techniques

Clean weld area. It is not required to preheat but if base metal is highly carbonized it should be preheated to approx 200 deg C. Build part to desired shape by using as many passes as necessary.

Heat to bright red colour. Peen to relive stresses and remove slag between passes.

Use DC Reverse Polarity