Weltrode WC 8100H AC-DC

Premium Electrode For Cast Iron Draw Dies And Maintenance Welding (Iron Base)

Why Do Welders Choose Weltrode WC 8100H AC / DC

Weltrode WC 8100H is an all position AC/DC coated electrode, designed specially for highest hardness on cast iron draw dies and also used for cast iron maintenance to be used for the on the job repairs eliminating the necessity of dismantling the equipment producing porus-free weld deposit giving highest reliability

Special Features

- Used for build up of wearing surfaces on all types of iron draw dies including gray, nodular, ductile and special cast alloys.
- Can be used for joining steel to Cast Iron where high strength is required.
- Specially alloyed coating materials and fluxing agents produce porus free welds
- The flux coating of Weltrode WC 8100H does not contain " Barium" thus eliminating hazardous fumes during welding.
- Deposits are long wearing and develop a high polish while in service.
- All position welding possible

WELTRODE®
The Welding Technology

Typical Properties

Tensile Strength	**68,000 Psi**
Hardness	**RC 34-36 As Welded**
	RC 40-42 Work Hardened
Yield Strength	**47,000 Psi**
Elongation	**20%**

Applications

To be used where high hardness is required in draw dies such as draw beads hold down beads, high light lines and draw radii areas on female dies.

Used for cracked high alloy tool steel dies made from D-2, D-6, D-7 and other high carbon alloy steels

Recommended Amperage Settings

Diameter (mm)	3/32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	70	95
Maximum Amperage	85	125	150

Welding Techniques

Remove all rust, scale and scale from the surface to be welded. Adjust amperage within recommended range and deposit electrode, maintaining a short to medium arc length. Tilt the electrode 30 degrees in the direction of travel. Use stringer bead or moderate weave technique and back-whip all craters.

Use reverse polarity on DC.