Weltrode WC 8500 AC-DC

Premium Medium Hardness Electrode For Building Up Oil Soaked Cast Iron Draw Dies Without Porosity

Why Do Welders Choose Weltrode WC 8500 AC / DC

Weltrode WC 8500 is an all position AC/DC coated electrode low hydrogen electrode, for building up directly on cast iron base metals. The unique formulation of this electrode provides positive arc stability and superior high performance weldability.

Special Features

- Unique chemistry of Weltrode WC 8500 produces homogeneous porosity free weld deposits.
- Can be used for build up of wearing surfaces on all types of Cast iron draw dies Excellent Results on nodular, ductile and special cast alloys.
- The deposited metal shows low hardness but becomes hard after impact due to high work hardenability.
- Deposits are long wearing and develop a high polish while in service.

Typical Properties

Hardness	**RC 30-34 as welded** **RC 38-40 work hardened**

WELTRODE®
The Welding Technology

Application

Used for wearing surfaces on all types of Cast Iron Draw dies including gray, nodular, ductile and special cast alloys.

Used where high hardness is required on draw dies in areas like draw beads, hold down beads, draw radii areas on female dies specially on nodular, ductile and special cast alloys.

Excellent results on high alloy tool steel dies made from D2, D6, D7 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	60	80	100
Maximum Amperage	80	100	130

Welding Techniques

Remove all rust, scale, drawing compound and oil from the surface to be welded. Preheating to 150 deg C is effective though in many cases not necessary. It is recommended to use as low a current as possible. Peen rapidly to help relieve stresses. Clean off slag between passes.

Use DC Reverse Polarity