



Weltrode WC 7500 AC-DC

Premium Quality High Hardness Electrode For Most Tool Steels With Excellent Crack Resistance

Why Do Welders Choose Weltrode WC 7500 AC / DC

Weltrode WC 7500 Is An All Position AC/DC Coated Electrode Low Hydrogen Electrode , For Welding O , A and D Series Tool Steels The Deposited Metal Has A Martensitic Structure With Some Dispersed Carbides To Give It High Hardness . The Unique Formulation Of This Electrode Enables Multiple Layers For High Buildups

Special Features

- + Work Hardening Deposits Of Weltrode WC 7500 AC/DC Are Extremely High
- + Resistant To Abrasion And Metal To Metal Erosion
- + Special Alloying Chemistry Enables Multiple Layers With This Electrode
- + For High Buildup
- + Smooth And Spatter Free Operation Providing High Quality Porosity
- + Free Welds

Typical Properties

Hardness

**RC 46-48 As Welded
RC 55-56 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.

Recommended Amperage Settings :

Diameter (mm)	3/32 (2.5)	1/8 (3.15)	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 Appox 350 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 35