



Weltrode WC 7700 AC-DC

Superior High Hardness Electrode For Welding All Tool Steels

Why Do Welders Choose Weltrode WC 7700 AC / DC

Weltrode WC 7700 Is an all position AC/DC coated electrode low hydrogen electrode , for welding A and D Series tool steelsThe deposited metal has a martensitic structure to give it high hardness . The unique formulation of this electrode provides positive arc stability and superior high performance weldability .

Special Features

- ✦ The deposition of WC 7700shows extremely high abrasion resistance with high hardness
- ✦ Excellent operational characterstic with no blow holes
- ✦ Smooth and spatter free operation
- ✦ Unique chemistry of Weltrode WC 7700 provides it with high toughness . Has excellent crack and impact resistance
- ✦ The unique moisture proof low hydrogen coating assures high shelf life

Typical Properties

Hardness

**RC 45-48 as welded
RC 54-56 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.

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