

## CARBODUR WZ 51 B

International standards	DIN 85	55		E 3-UM-	·55-T						
Characteristics	CARBODUR WZ 51 B is a basic electrode with 140 % recovery. It deposits a wear resistant alloy and can be applied to reclaim hot-forging dies and to overlay the edges and flat areas of low alloyed high density steel tools.										
Typical applications	The electrode is typically applied on: slab shears, hot-forging dies, drawing dies, containers, crushing equipment and depressions created by forging, pressure and impact stress.										
Operating temperature											
Recommendations for welding and heat treatment	The preheat and interphase temperatures should be held at about 300° C depending on the base metal and its heat abduction. Normally, the higher temperature range should be chosen. Heat induction during low tension welding should be continually monitored. Slow cooling is recommended using sand or oven methods.										
Mechanical properties of all-weld metal	Hardness as welded HRc			Tensile strength R <sub>m</sub> N / mm³							
( typical values)	52-55		1740-1900								
Weld metal analysis	С	Si	Mn	Cr	Ni	Мо	W	V			
(typical, wt. %)	0,3	0,7	0,5	5,3	0,5	1,7	4,9	0,6	]		
Current	= +										
Welding positions	PA, PB	, PC									
Rebaking	1 h, 350 °C + / - 10 °C ( if required )										

Dia./Length	Amperage (A)	Pcs./ packet	Pcs./ carton	kg / 1000	kg / packet	kg / carton
2,5 x 350	60 - 80				5,0	20,0
3,2 x 350	80 - 130				6,0	24,0
4,0 x 350	130 - 170				6,0	24,0
5,0 x 450	160 - 200				6,0	24,0

Rev. 000

Statements on composition and application are just for the applier's information. Statements on mechanical properties always refer to the all-weld-metal according to valid standards. Carbo-Weld may change the characteristics of its products without notice. We recommend the applier to check our products for their special application autonomously.