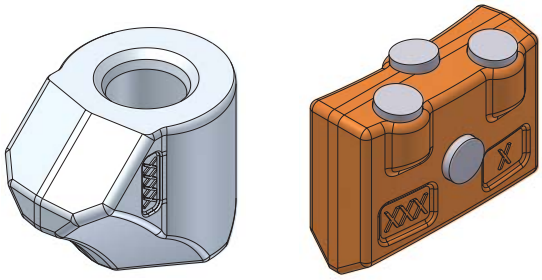
Welding instructions for toolholders and welding bars



Material

Micro-alloyed tempering steel 34MnCrB4+Ti B650

Analysis (Stated in %)	C	0,33-0,37
	Mn	1,35-1,50
	Cr	0,20-0,50
	B	0,0015-0,0050
	Ti	0,020-0,050
	Si	0,15-0,30
	Al	0,035-0,055
	S	0,02-0,035
	Cu	0,00-0,25
	Mo	0,00-0,06
	P	0,000-0,0045

Pre-treatment

Before welding, heat the holder to a temperature of about 250 °C to prevent cracking. Dry the electrodes for 2 hours with 300°C before using them.

Current source: Direct current

Recommendations for electrodes Inert gas welding (MAGC/MAGM)

DIN 8559	SG 3
DIN 8575	SGMo
AWS A 5.18	ER 70S-6
AWS A 5.28	ER 80S-G
SFA-5.18	ER 70S-6
SFA-5.28	ER 80S-G
B.S. 2901	A 3 0

Welding

- Multiple layer welding
- Heating should not exceed 350°C, as otherwise the strength of the basic material, tempered and quenched to 1450 - 1600 N/mm² is lost.
- In order to reduce the welding stress, the material should be allowed to cool down slowly.

Welding without inert gas

DIN 8529	EY 42 65 Mn B
DIN 8529	EY 4664 Mo B
DIN 8529	EY 4664 Mo
DIN 8575	E Mo B 29
DIN 8575	E Mo B 26
AWS A 5.1	E 7018DIN 8575
AWS A 5.5	E 7015-A 1
AWS A 5.45	E 7018-A 1
SFA-5.1	E 7018
SFA-5.5	E 7015-A 1
SFA-5.5	E 7018-A 1
B.S. 639	E 5154 B
B.S. 249	Mo BH
B.S. 2493	Mo BHJ

BETEK

Progress!