

WELCO FILLER METALS FOR TOOL STEELS

36" LENGTH TIG WIRE

TABLE – 36" LENGTH TIG WIRE – FILLER METALS FOR TOOL STEEL

TIG Alloy	Sizes	Stock No.	RC Hardness as Deposited	Preheat	Anneal	Harden	Post-heat	Quench	PRICE PER LB
3-AH	1/16	003AH30	48-52	300°F	1500°F	1750°F	300°F	Air	\$38.47
	3/32	003AH50		to	to	to	to		\$37.67
	1/8	003AH60		1000°F	1600°F	1850°F	1000°F		\$37.10
3-OH	1/16	003OH30	48-56	250°F	1425°F	1425°F	250°F	Oil	\$34.68
	3/32	003OH50		to	to	to	to		\$33.60
	1/8	003OH60		400°F	1450°F	1475°F	400°F		\$32.90
3-WH	1/16	003WH30	52-58	275°F	1425°F	1425°F	275°F	Water	\$24.80
	3/32	003WH50		to	to	to	to		\$23.60
	1/8	003WH60		450°F	1450°F	1500°F	450°F		\$23.10
3-HSS	1/16	03HSS30	58-63	1000°F	1600°F	2200°F	1000°F	Oil	\$55.51
	3/32	03HSS50				to			\$48.83
	1/8	03HSS60				2225°F			\$47.50
3-HW	1/16	003HW30	52-55	900°F	1500°F	1750°F	900°F	Air	\$38.80
	3/32	003HW50		to	to	to	to		\$34.40
	1/8	003HW60		1200°F	1600°F	1850°F	1200°F		\$33.58
3-FH	1/16	003FH30	45	800°F	Use S.A.E. 4130 Procedure				\$18.50
	3/32	003FH50		to					\$17.70
	1/8	003FH60		900°F					\$15.91

WELCO SUPER MISSILEWELD



FOR WELDING STEELS WITH HIGHEST STRENGTH AND MAXIMUM DUCTILITY (AC-DC)

Assures dense, non-cracking welds on "problem" steels such as high carbon steels; tool steels; stainless steels; spring steels; manganese steels; and dissimilar steels.

Applications: WELCO SUPER MISSILEWELD is particularly advantageous when the alloy content of the steel to be welded is unknown. This unique electrode is so versatile that its applications are virtually too multiple in number to specify. For years, it has been a maintenance and repair "stand-by" in every industry throughout the world.

Features:

- Tensile strength - Up to 120,000 psi
- Yield strength - Up to 85,000 psi
- Ductility - Up to 35% elongation in 2"
- Hardness as deposited - 200 to 300 Brinell
- Work hardens
- Impact resistance - Excellent
- Heat resistance - High
- Frictional resistance - Excellent
- Abrasive resistance - Mild
- Will not respond to heat treatment

Tool Steel Filler Metals & Super Missileweld

Preparation:
Prepare the same as for Tool Steel Filler Metals.

Procedure: TIG WELDING
Treat the same as for TIG welding stainless steel.

TIG Welding (stainless steel)
In TIG welding, the arc is struck between the work piece and the non-consumable tungsten electrode. The consumable wire is melted in the arc atmosphere and the inert-gases like Argon or Helium or their mixture are used as shielding gases. TIG is extremely suited to join thin sheets, tubes, and making root pass welding in pipes, since the heat input in this process is minimal. TIG welds do not cause any undercuts or excessive penetration and the distortion is lowest compared to any other welding process. TIG welds offer superior quality, but result in low productivity.
SHIELD with Argon gas.

PRODUCT and DESCRIPTION	SIZE	STOCK NUMBER	PRICE PER LB
3-SMW Super Missileweld	1/16"	03SMW30	\$24.50
	3/32"	03SMW50	\$23.50
	1/8"	03SMW60	\$22.50