

AKD007

Deposited metal hardness: HB $\geq$ 180

Description: AKD007 is a basic electrode for cast iron moulds. This electrode has stable arc, easy operation and excellent welding process performance. The deposited metal is ferrite and carbide dispersed structure, which has excellent crack resistance. The weld ment is not preheated before welding, and the deposited metal has no cracks after welding.

Application: This electrode is suitable for welding and repairing the surface of gray cast iron, ductile iron and alloy cast iron. For example, surfacing and repair welding of large cast iron rolling dies, cast iron forming dies and cast iron molds.

Typical Chemical Composition(%):

	C	Si	Mn	S	P	Mo	V	B
Actual Result	0.25	1.00	2.0-3.0	0.03	0.03	2.0-3.0	5.0-8.0	0.03

Recommended welding parameters:

Diameter/ mm	3.2	4.0	—	—
Electrode Length (mm)	350	350	—	—
Welding Current (A)	100-130	130-170	—	—

1. The electrode must be baked at 300-350℃ for 1 hour before welding

2. Rust, oil, moisture and other sundries on the weld ment must be removed before welding