

AKD950



Deposited metal hardness: HRC 50-55

Description: AKD950 welding rods are the new generation special welding rods for hot forging die imitated by American EUREKA company. The deposited metal has reasonable alloy composition and works at high temperature. The deposited metal does not soften and has good red hardness. It can replace 5CrMnMo, 5CrNiMo and other materials, Significantly improve mold life. The welding process performance is excellent, the shape is beautiful, the spatter is small, and the DC reverse connection is adopted.

Application: Used for surfacing and repairing hammer forging dies and machine forging dies.

Recommended welding parameters:

Diameter/ mm	3.2	4.0	5.0	—
Electrode Length (mm)	350	350	350	—
Welding Current(A)	100-120	160-190	190-230	—

1. The electrode must be baked at 350-400C for 1 hour before welding, and it can be used as it is baked
2. Remove the fatigue layer, cracks, oil stains, moisture, rust and other impurities on the surface of the workpiece before welding.
3. Before welding, it should be preheated according to the size and material of the workpiece to avoid cracking
4. After welding, heat treatment should be carried out according to the size and material of the workpiece