



Standards: DIN 8555

E 6 - UM - 60

Application / Properties: Basic electrode for repairing of molds especially 1.2080 cutting mold. This electrode can be used with or without buffer layer for 1.2080 steel.

Before welding, 1.2080 steel shall be preheat at 350 -400 C.

Weld metal analysis in % (typical values):

C	Mn	Si	Cr	Mo	W	V
0.5	0.4	0.9	6.5	0.45	1.3	0.6

Mechanical Properties of all -weld metal:

(Single values are typical values)

Hardness as -welding

57-62 HRC



Welding Parameters

Diameter (mm)	2.5	3.25	4
Length (mm)	350	350-450	350-450
Amperage(A)	70-100	100-140	140-180



Materials:

For repair of cutting molds

Rebaking: required at 300°C to 350°C for 2hrs.