

NIMOTEN 9580

HARD FACING (For Hot & Cold Working Dies)

ALLOY BASIS:

C, Cr, Mo, Ni, W, V

KEY FEATURES:

- Hard facing electrode produce crack free weld deposit
- Weld deposit is tough and resist high temperature wear
- Easy slag removal & smooth weld finish
- Excellent welder appeal & radiographic quality welds
- Can be machinable by grinding

TYPICAL APPLICATIONS:

- Press forging dies, Impactor dies
- Hot working tools & guides, Shear blades
- Coining dies, Header dies, H11 type forging dies
- Punches, Blanking, Trimming & Forming dies

PHYSICAL PROPERTIES:

Condition	3 Layer Hardness, HRC
As welded	56-60
SR at 550°C for 2 hours	55-58

Machinability

Abrasion Resistance

Impact Resistance

Corrosion Resistance



PARAMETERS - PACKING DATA:

∅ x L, mm	Amperage, A
3.15 x 450	100-140
4.0 x 450	150-180
5.0 x 450	190-250



AC (70 V)/DCEP

REDRYING CONDITION:
200-300°C for minimum 1 hour

Available in Standard carton packing of 20 kg box containing 4 cartons of 5 kg each. Also available in vacuum packing

Physical Properties: With increase in number of squares, property improves