

**AMTEC OH 70 OIL HARDENING TOOL STEEL**  
**DC REVERSE OR AC ELECTRODE**

**General Characteristics**

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Amtec OH 70 is an all position, medium alloyed, titania coated electrode suitable for welding oil hardening steel grades. The deposit reaches full hardness in the un-tempered condition. The properties and chemical composition of the weld metal corresponds to the conventional oil hardening steel grades, which are medium alloyed. The deposit of this electrode maintains excellent cutting power, shows high wear resistance, and is dimensionally stable. Use on AISI types O-1, O-2, O-7, L-6, 6F7, and S-1.

**Procedure**

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Clean the welding zone free from oil, rust and other contaminants. Grind out cracks and other defects, and pre-heat slowly and uniformly to 210-480°F. Do not exceed this temperature. Weld in small steps, according to the general welding instructions of the base metal, and keep preheating temperature within the specified range. A light peening after each deposit is recommended. After welding, cool in still air to 210°F and then temper for about ½ hour at a temperature of 210-570°F or the recommended temperature for the base metal. Cool slowly after tempering.

**Application**

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This electrode is primarily used for the welding of cutting tools, trimming knives for paper, and stamping dies. This electrode will produce sound welds on forming dies, blanking dies, shears, and other cutting edges.

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<b>Hardness (RC)</b>	<b>(as deposited) 62-65</b>		
<b>Alloy Type</b>	<b>Carbon-Silicon-Manganese-Chromium-Molybdenum- Vanadium Tungsten Type</b>		
<b>Heat Treatment</b>	<b>Use O-1 Procedure</b>		
<b>Diameter (Inch)</b>	<b>3/32</b>	<b>1/8</b>	<b>5/32</b>
<b>(mm)</b>	<b>2.5</b>	<b>3.2</b>	<b>4.0</b>
<b>Amps (approx.)</b>	<b>60-80</b>	<b>90-120</b>	<b>120-150</b>

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\* Also available in tig wire 1/16 and 3/32 by 36" lengths/.035 and .045 mig wire on 25 lb. spools

**CONFIDENTIAL INFORMATION**  
Subject to change without notice

**Tip Color – Plain**  
**Green Coating**