



AMTEC SR 71 SHOCK RESISTING TOOL STEEL

DC REVERSE OR AC ELECTRODE

General Characteristics

Amtec SR 71 is an all position, extremely high alloyed, titania coated electrode that produces an exceptionally high shock resistant weld deposit that is dense, porous free, and completely heat treatable. Especially suited for cold working applications when heavy shock is involved. This product is designed for out of position welding when necessary, and the deposit takes a high polish. Suitable for welding the base metals of AISI types S-1, S-5, S-6, and S-7.

Procedure

Clean the welding zone free from oil, rust and other contaminants. Grind out cracks and other defects, or use Amtec 8 gouging electrode to remove unwanted metal. Preheat unit to a maximum of 600°F if it is an AISI "S" series tool steel. Be sure part does not exceed 600°F during any phase of the welding operation. On other base metals, pre-heat and post-heat accordingly. Deposit stringer beads and peening is advisable. After welding, cool in still air to 150°F. Temper at 600°F at one hour per inch of thickness for maximum hardness.

Application

This electrode has a wide versatility, making it ideally suited for many applications. Some examples include die cast dies, cold shears, header dies, chisels, punch and moil points for air hammer tools, blanking and bending dies, trimmer dies, and sledge hammer faces.

Hardness (RC)				(as deposited) 54-57
Alloy Type				Typical AISI S-7
Heat Treatment				Use S-7 Procedure
Impact Strength				Very High

Diameter (Inch)	3/32	1/8	5/32
(mm)	2.5	3.2	4.0
Amps (approx.)	60-90	75-125	125-175

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

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Subject to change without notice

Tip Color – Plain
Gray Coating