

LH 708



**HOT WORK TOOL
STEEL ELECTRODE**

PROPERTIES

The deposit is a high-quality, tough, wear-resistant, free from cracks and porosities. The weld beads are smooth and uniform.

PROCEDURE

Clean the area with wire brush. Preheat the job to 300-400°C. Deposit LH 710 as a base layer for higher thickness and buildups. Deposit holding the electrode perpendicular to base metal - maximum 2 layers of LH 708 to get full hardness.

WELDING CURRENT

CURRENT	LENGTH	AMPS
AC / DC (+)	2.5x350	50-70
	3.2x350	90-110
	4.0x350	140-160
	5.0x350	190-230

TYPICAL APPLICATIONS

Used for repair of tools of similar materials or fabrication of hot work tools of carbon steels or low alloy steels, dies, stampers for nonferrous metals, saddle tracks, forging hammers, distributor pins, slides, hot shear blades, trimming dies, etc.

HEAT TREATMENT

Annealing

4 hours at 750-780°C

Hardening

1070-1120°C, quenching in oil

Tempering

Two hours at 500-600°C



SPECIFICATIONS

ALLOY BASIS: W, Cr



TECHNICAL DATA

Hardness (as welded) 41-46 HRC
(after hardening) 49-51 HRC
(after annealing) 21-24 HRC