

DESCRIPTION

Stoody M7-G deposit is a molybdenum high speed tool steel similar to AISI M7 grade. This material is characterized by a high hardness (58 to 66 HRC) and excellent wear resistance. Can be used at elevated temperatures up to 1000°F, under conditions of moderate thermal shock.

PREHEAT

Preheat is dependant on base metal requirements. Preheat high speed steels from 750°F to 1200°F. On base metal other than high speed tool steel, preheat and post heat accordingly. Maintain temperature during welding.

TYPICAL DEPOSIT CHARACTERISTICS

Abrasion Resistance	Good
Impact Resistance	Good
Deposit Layers	2 – 3
Hardness	HRC 58 – 66

ALLOY TYPE

High Speed M7 Tool Steel

TYPICAL APPLICATIONS

Typical applications include:

- Hot and Cold Dies
- Blanking Dies
- Piercing Dies
- Tire Shredders
- Cutting and Shaving Knives
- Shear Blades
- Excellent for cladding high wear areas on equipment and also for building up composite dies and tools.

OPERATIONAL CHARACTERISTICS / WELDING PARAMETERS

Diameter, In. (mm)	0.045 (1.2)	1/16 (1.6)
Current, Amp. DCRP	125 – 180	200 – 300
Voltage	18 – 20	24 – 28
Wire Extension	1/2"	1/2" – 3/4"
Shielding Gas	75% Ar / 25% CO ₂	75% Ar / 25% CO ₂
Diameter, In. (mm)	5/64 (2.0)	
Current, Amp. DCRP	250 – 350	
Voltage	25 – 29	
Wire Extension	1/2" – 3/4"	
Shielding Gas	75% Ar / 25% CO ₂	

STANDARD SIZES & PACKAGING

Diameter	Packaging	Part #
.045" (1.2mm)	33# WB	11810800
.045" (1.2mm)	50# PP	11849400
1/16" (1.6mm)	33# WB	11868500
1/16" (1.6mm)	50# PP	11834200
1/16" (1.6mm)	200# HP	11917900
1/16" (1.6mm)	400# NTP	11925500
5/64" (2.0mm)	33# WB	11916500

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