



Manufacturers of Custom Welding Lines for Resale
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SELECTRODE 6001

M2 High Speed Steel TIG

INTERNATIONAL CLASSIFICATIONS

None

FEATURES & APPLICATIONS

Ideal to use where excellent wear resistance is needed at high temperatures. Deposits are dense and have high resistance to abrasion and frictional wear. Maximum hardness is retained at temperatures up to 1100° F. Use on hot and cold trimming dies, blanking dies, piercing dies, shear blades, cutting and shaving knives. Excellent for cladding high wear areas on equipment.

ALL WELD METAL ANALYSIS (TYPICAL WEIGHT %)

C	Mn	Si	Cr	W	Mo	V
.85	.28	.30	4.15	6.15	5.0	1.85

TYPICAL MECHANICAL PROPERTIES

Hardness 61-63 RC as welded

Heat Treatment Use M-2 Procedure

Use DC- 100% argon gas

Welding Techniques: Completely clean the area to be welded, remove all fatigued metal, and round off sharp edges. Slowly and uniformly preheat according to base metal specifications and maintain temperature throughout the welding procedure. Try to position part so welding can be done on a slight incline. Use the smallest diameter filler rod and lowest amperage possible to minimize heating of the part yet providing for a stable arc and suitable weld penetration. Amperage will be dictated by the thickness of the base metal and tungsten diameter. Argon shielding gas is recommended. Skip weld if necessary to distribute heat evenly, do not heat base

metal beyond the tempering temperature to avoid loss of hardness. Lightly peen each bead while still red hot to relieve stresses. Allow the part to cool slowly in still air, if welding in a cool environment, take measures to provide for slow cooling of the finished part such as use of a furnace or a suitable insulating material. When part cools to about 200°F, post heat to base metal specifications and slow cool to ambient temperature.