



Weld Mold Company
*Serving the welding
industry since 1945*

750 Rickett Rd.
Brighton, MI 48116
(810) 229-9521
fax (810) 229-9580

WELD MOLD 545

DESCRIPTION:

Expressly made for welding both wrought and cast steel structures. Similar in composition to the 540 but with increased hardness and wear resistance.

APPLICATIONS:

For heavy buildup and overlays on equipment that requires high impact and wear properties at temperatures up to 1000°F. May be used on certain forge or press die applications.

PROCEDURE.

Remove all defects; heat checks, spalls, and cracks. Preheat the unit to a minimum of 800°F. Maintain this temperature during welding. Utilize short arc length. Peening is necessary when filling in small cavities. Peen after depositing each pass. Peening is not necessary when welding large areas such as complete impressions except on the final pass. After welding, cool the unit in still air to approximately 350°F. This is necessary to produce uniform weld hardness. When the cooling temperature is reached, immediately charge dies into a furnace at 1050°F and temper for 12 to 16 hours. On rams and sow blocks, etc., stress relieve at 1150°F. for 12 to 16 hours. Stress relieve hammer bases at 1150°F at one hour per inch of thickness at temperature. Remove the unit from the furnace and cool in still air to room temperature.

SMAW

DC+

FCAW

DC+, 100%CO₂

Or 75%-25% CO₂

TECHNICAL DATA:

Available Processes:

SMAW and FCAW

Hardness:

Rockwell C 40-45

Machinability:

Tough

Alloy Type:

Nickel-chromium-molybdenum