



Weld Mold Company
*Serving the welding
industry since 1945*

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WELD MOLD 954

DESCRIPTION:

A machinable material especially designed for hot work applications. Special alloying agents produce the ultimate in homogeneous porous-free high-density weld deposits. Machinable weld deposits are obtained from Weld Mold 954 that incorporate excellent thermal shock and wear resistance as well as toughness.

APPLICATIONS:

Primarily used for overlays and complete impression welds on press forging dies. Other uses that are suited for this material include upsetter insert dies, hammer dies, wearing surfaces and all A.I.S.I. series hot work tool steels where machinable welds are necessary. Not recommended for use in working areas of aluminum die casting dies.

PROCEDURE:

For touchup repairs on forging dies a localized preheat of 400° F to 500° F is sufficient with a slow cool. Be sure to remove all oxides and other foreign matter from the area before welding. For full impression welds on die blocks preheat to 900° F. Maintain interpass temperature during welding. After welding, cool in still air to 300° F to obtain ultimate grain refinement. Temper at 1050° F for one hour per inch of thickness.

SMAW

DC+

GMAW

DC+, 92%Ar-
8%CO₂ or 100%Ar

GTAW

DC-, 100%Ar

FCAW

DC+, 100%CO₂
or 75%Ar-25%CO₂

TECHNICAL DATA:

Available Processes:

SMAW, GMAW, GTAW and FCAW

Hardness:

Rockwell C 36-40 SMAW & FCAW

RC for GTAW & GMAW will run 3-4 points lower

Machinability:

Good

Class:

Machinable Hot Work