



Weld Mold Company
*Serving the welding
industry since 1945*

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WELD MOLD 988

FEATURES:

A highly versatile product made primarily for hot work applications where severe conditions exist. The addition of cobalt greatly increases heat and abrasion resistance. 988 exhibits reduced thermal fatigue and heat checking compared to other hot work overlays. It also performs well in cold work application with high resistance to metal-to-metal wear.

APPLICATIONS:

For heavy-duty hot shears, forge die inserts, hot punches, extrusion dies, hot metal shearing and forming operations. 988 has produced outstanding results in cold metal forming operations where metal scoring and pickup is a problem such as stamping dies.

PROCEDURE:

Prepare all repair areas by removing cracks, checks, fatigued-metal and all foreign substance. Preheat will be dictated by the base metal. Tool steels are typically preheated between 850° F and 1100° F. Maintain interpass temperature throughout the welding operation. Deposit stringer beads and peen deposits while forgeable. After welding cool to below 150° F. Tempering temperature will be based on desired hardness. A temper chart for this material is available upon request.

SMAW

DC+, Hold a
short arc

FCAW

DC+, 75%Ar-
25%CO₂ or 100%
CO₂

TECHNICAL DATA:

Available Processes:	SMAW and FCAW
Alloy Type:	Tungsten-Chrome-Cobalt, Hot Work
Hardness:	Rockwell C 54-57, as welded
Heat Treatment:	Use H-19 Procedure