

# FORGEWELD

*Performance Welding Consumables For The Tool And Die Repair Industries*

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Unit 3 Johnson House, Bilston Industrial Estate.  
Oxford Street, Bilston. WV14 7EG

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Tel : 01902 408309 Fax : 01902 494939. Mobile : 07831 137037  
www.forgeweld.co.uk sales@forgeweld.co.uk

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## FORGEWELD MAG/TIG52

### ■ Description & Applications :

Superior wire for overlaying a whole range of tool and die applications where general hard surfacing is required to give > 50HRc. FW52 has primarily been developed along the lines of the popular H13 Type wires for the repair and rebuilding of hot working tool and dies.

FW52 structure has been slightly developed to give a smoother deposit and a slightly better wear performance than a normal H13.

The alloy deposit ensures air hardening characteristics coupled with excellent toughness and abrasion resistance at particularly high temperatures.

### ■ Typical All Weld Metal Chemical Analysis % :

C	Cr	Mn	Mo	Si	S	P	V
0.39	4.94	0.37	1.23	1.03	0.003	0.017	0.42

### ■ Properties :

As deposited : 50 - 52 HRc

After tempering at 500 deg c - 550 deg c 52 - 54 HRc

### ■ Shielding Gas :

TIG : Pure Argon with back purge where necessary

MIG : Pure Argon or Ar + 5% CO<sub>2</sub>

### ■ Sizes Available and Recommended Amperages

TIG : 1.6mm 2.4mm

MIG : 1.2mm

### Storage

Keep in a dry area, do not allow to become damp as moisture may be transferred into the weld metal.