

ANVILOY® WELD ROD

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enhancement of casting tools made from hot-work steels such as 1.2343 / H-13
or repair of tools, dies and inserts made of tungsten alloys

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Anviloy® is a tungsten-based TIG-welding filler metal available as rod or wire.

Applicable to the following materials

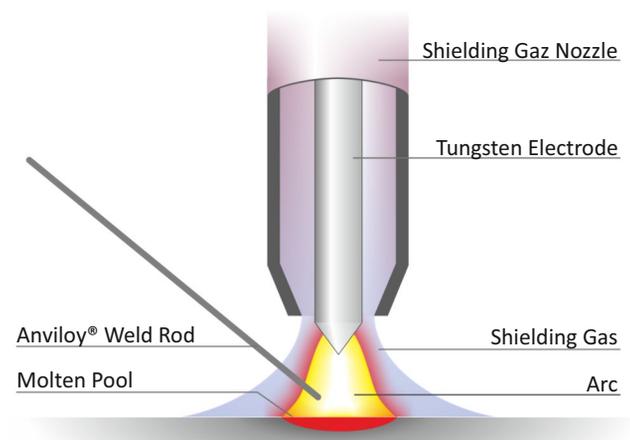
- Hot-work steels such as 1.2343 / H13
- Tungsten Alloys

Major Applications

- Repair of cracked or broken dies
- Reconstruction of outbreaks and washouts
- Armor, strengthen or recoat areas where heat transfer needs to be enhanced
- Armor, strengthen or recoat areas exposed to high erosion or corrosion

Advantages

- Increase the resistance to thermal wear and heat checking
- Increase erosion and / or corrosion resistance
- Reducing the tendency to soldering
- Remove heat faster from die casting components



Available European Standard Sizes (mm | inch)

Diameter	1,6 1/16"	2,4 3/32"	3,2 1/8"	
Length	175 7"	305 12"	457 18"	1.000 40"

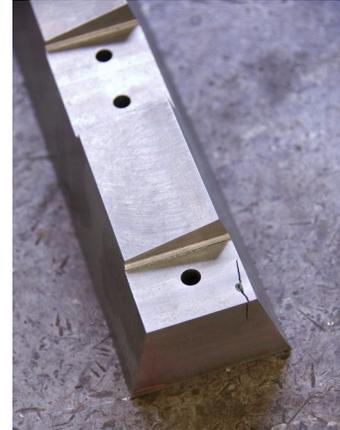
Other dimensions available on request

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How to use

- Machine the work piece to approx. 6 mm below working surface
- Avoid sharp corners. Use radii and fillets
- Clean the application surface thoroughly
- Use a suitable TIG-welding machine (DC, HF ignition, 150-200 amps)
- Assure proper shielding gas protection
Argon with appropriate flow rate, pre-purge torch and weld area, post-purge weldment until cooled down below 400°C
- For best results the use of a gas lens is recommended
- Heat pretreatment depending on material and application
- Never heat with acetylene torch or equipment
- Keep weld build-up thickness to 12mm or less
- Stop welding as soon as oxides form on the weld
- Avoid strong blending of the base material with Anviloy® Weld Rod
- The weld should have smooth, even edges without porosity
- In case of spatter or bubble formation during welding, stop the process and remove any impurities and oxides from workpiece, Anviloy® Weld Rod and electrode surfaces

All recommendations and/or suggestions related to the use, storage, handling or properties of the products manufactured and/or supplied by Weldstone GmbH regardless of the form of communications is given in good faith. It is the user's responsibility to reach their own satisfactory conclusion regarding the suitability of any product for a particular application and under its own particular circumstances. Weldstone GmbH strictly limits its warranty to manufacturing its own products free from all material defects and this warranty does not extend to applications. Remedies are strictly limited to repair and/or replacement of the product.



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