

# MF 607

## ALL PURPOSE TOOL, DIE AND MOULD STEEL ELECTRODE



- Sought after welding alloy for all tool & die steel application
- Can Be Used Hot And Cold Working Tools Steel
- In Some Cases It Can Be Used For Metal To Metal



# MF-607

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## SPECIAL BENEFITS

- **MF 607** Universal Tool Die Steel Electrode
  - **MF 607** Is specially manufactured alloy for all tools, die and mould steel. Welds practically all tools & die steels in hardened condition
  - **MF 607** Reduced need for preheating makes it the choice for crack- sensitive steels
  - **MF 607** Is the multi-purpose electrode for tool, die mold steel
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## OUTSTANDING PROPERTIES:

- Provides hardness of 58-62 Rockwell C
  - Can weld and also AISI (SKD-11) D2, A2, S1, H13 and L6 Tools Steel
  - Is suitable for both hot- and cold-working conditions
  - Produces a surface which can be finished to desired dimension by grinding
  - Alloying elements tungsten, molybdenum and vanadium guarantees perfect performance
  - Weld metal maintains many of its properties at elevated temperatures
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## RECOMMENDED FOR:

**MF 607** is recommended for repair and hardfacing of:

- Hot-working and cold-working dies
- Forming & drawing dies
- Metal stamping dies
- Any kind of tool refurbishment
- Hot- and cold-shear blades.
- Forming & blanking dies
- Rotary shear knives
- Rebuilding work

**MF 607 HIGH HARDNESS TOOL STEEL ELECTRODE  
FOR HIGH SPEED TOOL STEELS**



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## MECHANICAL PROPERTIES:

### Undiluted Weld Metal

Hardness (as welded)

Hot Hardness

Heat Treated Hardness

### Maximum Value Up to:

Rockwell C 58-62

Rockwell C 56 at 1100°F (600°C)

Rockwell C 63-65

**RECOMMENDED CURRENT:** DC Reverse (+), (-) or AC

## RECOMMENDED AMPERAGE SETTINGS:

Diameter in (mm)	3./32 (2.5)	1/8 (3.25)	5/32 (4.0)
Minimum Amperage	45	80	110
Maximum Amperage	90	120	150

**WELDING POSITIONS:** Flat, Horizontal

## WELDING TECHNIQUES:

When welding on tool steel, if preheat is not adversible peeing could be done.

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