

# QuFe72

(W.-Nr. 1.6356)

is used for repair, preventive maintenance and production of highly stressed cold and hot working tools, such as punching tools, cold shears for thick materials, drawing-, stamping - and trimming tools, hot cutting tools, Al-die cast moulds, plastic moulds, cold forging tools. The weld deposit is, in as-welded condition, easily machinable and the subsequent age hardening optimises the resistance to wear and alternating temperatures.

### Recommended for:

Cold- and warm working steel with high stress

### Hardness of the pure weld metal:

untreated: 34 - 37 HRC  
 After age hardening 3 - 4 h / 480° C 50 - 54 HRC

### Rework

age hardening, nitrated, chrome-plated, CVD coated, polished and machined

### Material analysis in %

C	Mo	Ni	Co	Ti	Al	Fe
0,02	4,0	18,0	12,0	1,6	0,1	Rest

(test certificates upon request.)

### Standard/Mechanical Values

Ø	N / mm <sup>2</sup>	elongation AL100	Items on stock	
			rods	spools
0,2	-	-	-	-
0,3	-	-	X	-
0,4	1300	2,3	X	-
0,5	1412	2,8	X	-
0,6	-	-	X	-
0,7	-	-	-	-
0,8	-	-	X	-

### Hardness after welding

Ø	HRC	base material
1. layer		
2. layer		
3. layer		

(results on request)

### Following standard:

#### Laser welding wires

rods: 333 mm / 1.000 mm  
 spool: K80 / K125 / K250 / SH253 / MA125

(The reported values were determined by the manufacturer and / or by a neutral Laboratory determined. For the accuracy we can not guarantee)