

ANVILOY® WELD ROD

Die Enhancement & Repair

A unique tungsten-based TIG filler metal used for enhancing and repairing dies and inserts. These weld rods work equally as well on both tool steel and tungsten based materials.



USES & BENEFITS

- » Repair cracked or broken dies
- » Reconstruction of outbreaks and washouts
- » Repair or enhance casting tools and cores
- » Armor, strengthen or re-coat areas exposed to high erosion or corrosion
- » Increase the resistance to thermal fatigue and heat checking
- » Increase erosion or corrosion resistance
- » Reduce the tendency to soldering

Resurfacing or repairing a die with ANVILOY® Weld rod will increase resistance to thermal fatigue and heat checking as well as enhancing its resistance to die soldering.

Available Sizes	18" Lengths (457mm)	12" Lengths (305mm)	7" Lengths (175mm)
0.062" (1.6mm)	AWR16-18	AWR16-12	AWR16-7
0.094" (2.4mm)	AWR332-18	AWR332-12	AWR332-7
0.125" (3.2mm)	AWR18-18	AWR18-12	AWR18-7

Distributed by:

PRODUCTION ENGINEERING

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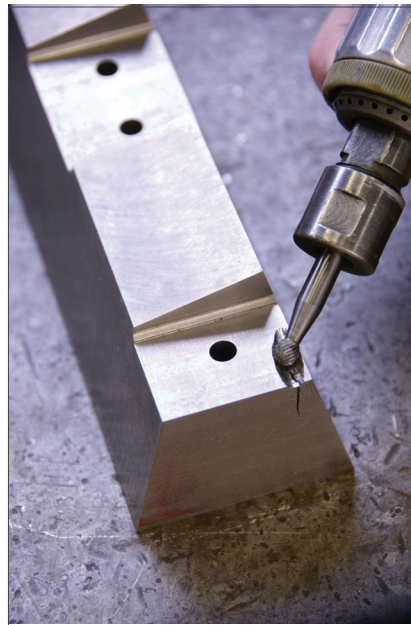
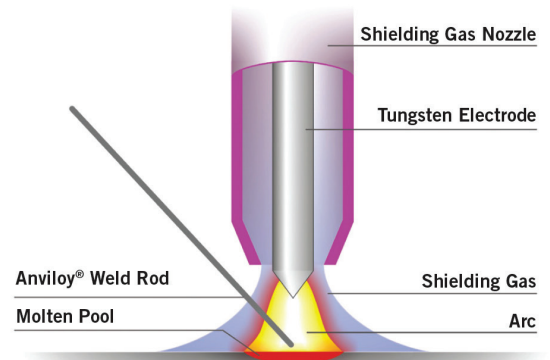
www.resistanceweldsupplies.com

ANVILOY® WELD ROD

ANVILOY® WELD ROD USERS GUIDE

RECOMMENDATIONS FOR BEST RESULTS

- » Machine the work-piece to approx .250" below working surface.
- » Avoid sharp corners. Use radii and fillets
- » Clean the application surface thoroughly
- » Use a DC TIG welding machine with high frequency ignition, adjusted to suitable amperage
- » Assure proper shielding gas protection (pre-purge torch and weld area, post-purge weldment until cooled down below 750 °F) 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 1/2" or less
- » Weld should have smooth, even edges without porosity
- » If contamination or porosity occurs, remove to sound metal and assure that the electrode and weld rod are free of contamination before proceeding with the repair
- » Stop the weld as soon as oxides form on the weld
- » Avoid strong mixing of the base material with Anviloy®



All recommendations and/or suggestions related to the use, storage, handling or properties of the products manufactured and/or supplied by Astaras, Inc. regardless of the form of communication 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. Astaras strictly limits its warranty to manufacturing its 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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