



ENAR WELD BRAZE PVT. LTD

A-112, DDA INDUSTRIAL SHEDS,
OKHLA INDUSTRIAL AREA, PHASE – II
NEW DELHI – 110020

Telephone : 011-26383911/12/13
Fax : 011-26383913
E-Mail : info@enarweld.com

ENAR – EWMR H13

Classifications:

Werkstoff: 1.2344
AISI: H13

Typical Chemistry Composition of Weld Deposit:

| C | Si | Mn | P | S | Cu | Cr | Mo | V |
|------|------|------|--------|--------|-------|------|------|------|
| 0.35 | 0.50 | 0.80 | <0.025 | <0.025 | <0.25 | 1.70 | 0.45 | 1.00 |

Description:

- EWMR H13 TIG/MIG is a 5% Chromium, Tungsten-free hot work tool-steel wire that produces dense, fine grained, heat treatable deposits with resistance to abrasions, frictional wear and mild impact in water cooled hot working surface.
- EWMR PH13 is not susceptible to brittleness to common grades H20-26 when used at a normal working hardness of HRC 45-55. Likewise, the higher alloy content of H20 to H26 makes the unsuitable for water cooled service.
- Deposits obtained are approximately 34-38 HRC as applied and can be flame hardened to 54-60 HRC with almost no hardness drop-off across the entire width and depth of the weld.

Typical Applications:

It is specially adapted to hot die work of all kinds, particularly for white metal (Aluminium, Magnesium and Zinc) and H Steels (H11, H12, H13 etc.) extrusion dies and die casting dies, forging dies, mandrels, hot piercing dies, header dies and hot shears.

Typical Mechanical Properties:

Yield Strength
(Mpa)
min. 900

Tensile Strength
(Mpa)
min. 1050

Hardness
(HRC)
54 - 60