AmAlloy® 814H

ENHANCED ALLOY FOR HARD SURFACING APPLICATIONS REQUIRING HEAT, SPALLING, & SEVERE CRUSHING RESISTANCE

"Made for LaBounty Shears"

GENERAL CHARACTERISTICS:

A superior all position electrode especially designed for hot work applications. Special alloying and fluxing agents produce the ultimate in homogenous porous-free high density weld deposits.

APPLICATIONS:

Primarily used for overlays and complete impression welds on press forging dies. Other uses that are suited for this material include upsetter insert dies, hammer dies, wearing surfaces, LaBounty Shears and all A.I.S.I.H series hot work tool steels.

TECHNICAL DATA:

Alloy Type	Cr-Ni-Mo-W
Hardness	RC 42-44
Machinability	By Grinding Only

Amperage

	80-125	125-175	175-225
(in)	1/8"	5/32"	3/16"

PROCEDURE:

For touch-up repairs on forging dies, a localized preheat of 400°F is sufficient with a slow cool. Use AC or DC reverse polarity after grinding or scarfing defective areas for repair applications. Be sure to remove all oxides and other foreign matter from area before welding. For full impression welds on die blocks, preheat to 900°F. Maintain temperature during welding. After welding, cool in still air to 300°F to obtain ultimate grain refinement and completed transformation on austenite in weld deposit. Temper at 1050° at one hour per inch on thickness at temperature.

Manufactured by AmAlloy Industries®
To Order - Call: 507-373-1677 or 800-735-3040
or E-mail: amalloyindustries@gmail.com
www.amalloy.com