



EAGLE 647

Superior hardfacing electrode for high speed and hot working tool steels.

APPLICATIONS

For hardfacing on dies, punches, molding plates, drawing mandrels, hot shears, trimming plates, debarker knives, mill cutters and planing tools.

PROCEDURE

AC or DC reverse polarity (+). Use the grinding method or remove fatigued metal using the **EAGLE 188**. Use lowest effective amperage while maintaining a medium arc length, making stringer beads to reduce heat input. On low carbon steels it may be necessary to use a minimum of three layers to overcome dilution. When welding on tool steel, pre heat the part to 800⁰F - 1000⁰F.

GENERAL CHARACTERISTICS

The **EAGLE 647** is a high quality, all position electrode for use on high speed and hot working steels. The alloying content of molybdenum, tungsten and vanadium will produce a deposit that will maintain a sharp edge on high speed tools and the deposit will retain its hardness and resistance to wear at the high operating temperatures.

TECHNICAL DATA

Tip Color:	Red			
Hardness: (RC)	As Welded	Approximate 58 - 62		
Hardness: (RC)	As Heat Treated	Approximate 62 - 64		
Current:	AC - DC Reverse (+)			
Sizes: (IN)		3/32	1/8	5/32
(MM)		2.50	3.25	4.00
Amperage:		45 - 90	90 - 125	130 - 180

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