



# EAGLE 646

*Tool Steel Hardfacing*

## APPLICATIONS

For hardfacing on dies, punches, shears, debarker knives, mill cutters and planing tools.

## PROCEDURE

Use 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 either 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 1000°F.

## GENERAL CHARACTERISTICS

The **EAGLE 646** is a high quality alloy for use on high speed and hot working steel.

## TECHNICAL DATA

Tip Colour: Black  
Hardness: (RC) As Welded Approx. 60 - 62  
Hardness: (RC) Heat Treated Approx. 62 - 64

## WELDING PARAMETERS

Current:	AC or DC Reverse [+] Polarity			
Sizes:	Inches	3/32	1/8	5/32
	mm	2.50	3.25	4.00
Amperage:	45 - 90	90 - 125	130 - 180	



≡ HIGH QUALITY WELDING PRODUCTS ≡

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