

**Typical Properties:**

Electrodes	Flux Cored Wire	MIG Rods	TIG Rods
<b>Hardness:</b> 49-54 HRC	<b>Hardness:</b> 49-54 HRC  <b>Shielding Gases:</b> 75% Argon, 25% Co2 90% Argon, 10% Co2 92% Argon, 8% Co2 100% CO2 may produce lower quality arc conditions  <b>Gas Flow Rate:</b> 045" 1.2 mm 20-50 CFH 1/16" 1.6mm 30-60 CFH 3/32" 2.4mm 80-120 CFH 1/8" 3.2mm 80-120 CFH Use DC Current with a Stick Out of 1/4"-1 1/4" (6mm-32mm)	<b>Hardness:</b> 49-54 HRC  <b>Shielding Gases:</b> 75% Argon, 25% Co2 90% Argon, 10% Co2 92% Argon, 8% Co2 100% CO2 may produce lower quality arc conditions  <b>Gas Flow Rate:</b> 20-60 CFH	<b>Hardness:</b> 49-54 HRC  <b>Shielding Gases:</b> 100% Argon  <b>Gas Flow Rate:</b> 20-40 CFH

**Specifications:**

AISI H13

EN10204 3.1 2.2

**Description:**

WT H-13 is often used for welding hot work tool steels with good heat checking resistance, hot tensile properties, as well as high wear resistance. It is often used in dies, screws, pneumatic hammers, punches, etc. It is available in electrode, flux cored wire, MIG and TIG rods. H-13 flux cored wire has a smooth spray transfer arc and a thin slag system. The weld deposits are porous and crack free. The MIG rods are spooled to ensure a smooth wire feeding that allows for a spatter free arc. The electrodes are designed for superior weldability with easy slag removal, spatter free, and a stable arc. The TIG rods are cut to length and have clean weld deposits.

**Chemical Composition (Wt%)**

C	Cr	V	Mo	Mn	Si
.35	5.0	1.0	1.5	.80	.80

Note: Single values are maximum unless otherwise noted.

**Maintaining a proper welding procedure, including pre-heat and interpass temperatures, may be critical depending on the type and thickness of material being welded.**

**CAUTION:** Consumers should be thoroughly familiar with the safety precautions on the warning label posted in each shipment and in the American National Standards A49.1, "Safety in Welding and Cutting," published by the American Welding Society, 8669 NW 36 Street, #130, Miami, FL 33126; OSHA Safety and Health Standards 29 CFR 1910 is available from the U.S. Department of Labor, Washington, D.C. 20210.