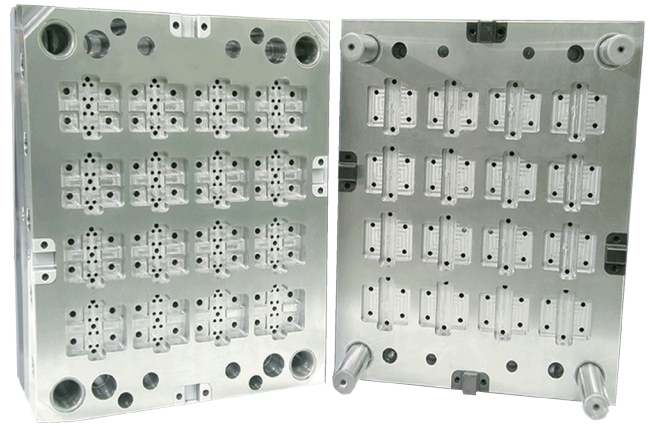


# Introducing NAK80 Steel

## High Performance High Precision Mold Steel 40 HRC Pre-Hardened

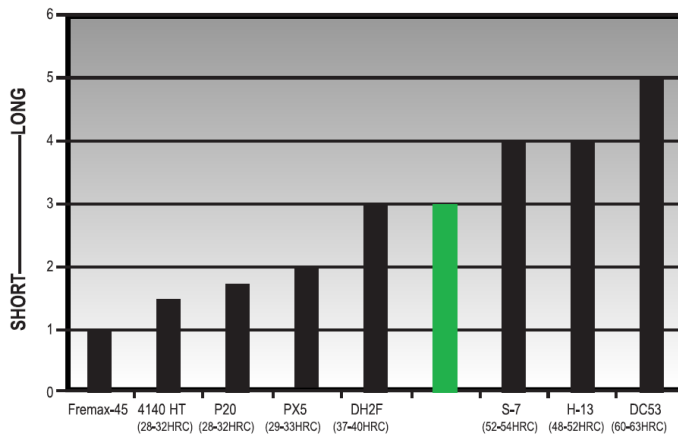
We are the EXCLUSIVE NAK80 Mold Base and Mold Plate Supplier.

- Available sizes from 8" x 8" up to 24" x 35" in all thicknesses
- An alternative to P20 High Hard with superior benefits
- Machines 10% to 15% faster than P20
- Uniform microstructure and hardness (between surface and interior)
- Never needs stress relieving
- Highly weldable
- Highly polishable for lens quality molds
- Easily machined with quality carbide tooling



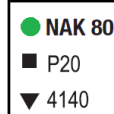
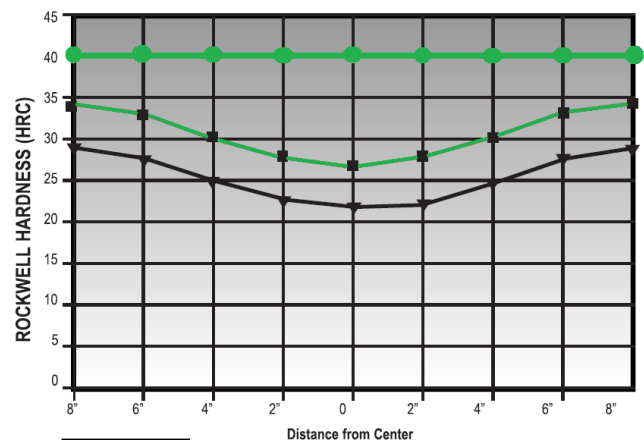
### MATERIALS / MOLD LIFE

General purpose molding material for mass production.



### NAK80 HARDNESS DISTRIBUTION

Shows uniform hardness distribution through the center.



**Request NAK80 on your next Mold Base project!**  
Send quote request to: [moldquote@pcs-company.com](mailto:moldquote@pcs-company.com)

# Welding Guidelines

Welding of NAK80 should be performed employing only NAK-W Welding Rods. NAK-W Welding Rods are copper-coated for either TIG or Heli-Arc welding. Employ only recognized, safe shop welding practices.

## General

- 1) The die or mold should be free of all oil, rust, scale residue or any other potential contaminants before attempting to weld.
- 2) All cracks and surface treatments should be completely removed before attempting to weld.
- 3) Sharp comers should be rounded to a minimum radius of .120"
- 4) To repair a crack, remove sufficient stock to repair the crack and insure only sound material remains. Dress the comers where stock was removed to eliminate any square comers by rounding to a minimum radius of .120".

## Conditions

<u>Rod Diameter</u>	<u>Electrode Diameter</u>	<u>Current/Amps</u>
.047"	.047"	40~70
.0630"	.0630"	70~150
.0946"	.0946"	150~250

## Preheating

Prior to making a welding repair, preheat the piece to be repaired, by slowly heating in a furnace or with a gas burner to between **600° and 750°F**. Heating from the bottom is recommended if a gas burner is used. Uniform temperatures within the recommended range should be maintained during the entire period of time required to complete the repair. Ideally the entire mold should be heated in a furnace to achieve uniform temperatures. This is easy to do for small molds, but may not be practical or possible for large molds. Localized preheating is the only option for large molds, and attention must be paid to the following:

- 1) Preheating temperature must be achieved to at least 2" away in all directions from the area to be welded.

- 2) Use an Oxygen-Propane gas burner with a low flame temperature. Heat the mold carefully and gradually, maintaining a distance of 18" between the flame and the mold surface.
- 3) Apply a temperature choke or a surface contact thermometer to accurately measure the preheating temperature.
- 4) Re-heat as necessary during welding to maintain the above 600°F range.

## D Post-Weld Heating

It is imperative that the following procedure be carefully followed to assure the welded section is completely restored to a uniform hardness:

The weld-repaired piece should be heated to between **860° - 940°F** and held at this range for a minimum of one (1) hour to re-age. This re-aging process should be conducted immediately after welding. Heating with a furnace is highly recommended, however a gas burner may be used as a last resort. If a gas burner is used, heating from the bottom is recommended, however the entire welded area, and as much as 2" surrounding the weld, must be kept in the post heat temperature range for a minimum of one (1) hour. Cool slowly to room temperature.

**Note:** Post-weld heating should be performed after every 3 layers of weld buildup in order to alleviate welding stress and avoid over-aging of adjacent parent metal.

## Technique:

- Use DC normal polarity.
- Use lowest possible amperage for the job.
- Use backhand welding - weld away.
- Use smallest diameter rod possible.
- Weld small beads.
- Peen weld as necessary.
- Upon completion of welding, proceed immediately to post-weld heating procedure.