



TECHNICAL INFORMATION SHEET

HARRIS 3AH AIR HARDENING TOOL STEEL

3AH tool steel TIG rod is for use with

- A-2 through A-10
- Air hardening dies
- Cold extrusion dies
- Blanking dies
- Draw dies
- Construction equipment
- Farm machinery
- Mining equipment
- Where abrasion resistance is required

Procedure:

- Clean weld area
- Preheat and recommended Inter-pass temperature 300°F to 1000°F depending on thickness of metal
- AC/ DC reverse polarity using lowest amperage setting.
- Use argon-shielding gas
- Use a striker plate to carry the arc to the weld area
- Use two or more passes to minimize dilution.
- Harris Super Missileweld recommended for the root pass
- Peen each pass
- Post heat - 300°F to 1000°F
- Annealing - 1500°F to 1600°F
- Hardening - 1750°F to 1850°F
- Quench - Air

Features:

Deposited hardness - RC 55-60

SAFETY INFORMATION:

WARNING: PROTECT yourself and others. Read and understand this information.

FUMES AND GASES can be hazardous to your health.

HEAT RAYS, (infrared radiation) from flame or hot metal can injure eyes.

- Before use, read and understand the manufacturer's instructions, Safety Data Sheets (MSDS), and your employer's safety practices.
- Keep your head out of fumes.
- Use enough ventilation, exhaust at the flame, or heat source, to keep fumes and gases from your breathing zone and the general area.
- Wear correct eye, ear, and body protection.
- See American National Standard Z49.1, *Safety in Welding, Cutting, and Allied Processes*, published by the American Welding Society, 8669 Doral Blvd., Doral, Florida 33166; OSHA Safety and Health Standards, available from the U.S. Government Office, Washington, DC 20402.

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