



ECOMold[®] 95

ECOMold[®] 135

Welding Guidelines

Feedback from material users that have welded the ECOMold type of products indicates that TIG welding with Argon is the preferred shielding gas for tool and die type welding. Brazing, gas welding and silver soldering are not recommended and did not show much success or promise.

Small parts do not need to be preheated, other than to warm the part enough to dry them of environmental humidity.

Large parts should be preheated to between 400 and 500 degrees F. This procedure is done primarily as a measure to keep the block itself from being a heat sink. If this measure is not taken, the cooler mass of the block will pull heat needed to melt away from the area of concentration.

During the preheating procedures, blocks should not be left in room air at elevated temperatures longer than actually needed to elevate to desired temperature. If blocks are left to preheat for excessive periods of time, copper oxides will form on the surfaces of the blocks which is potential contamination to weld area.

If oxides form, they should be cleaned from the immediate weld area, prior to weld procedure, with a wire brush or other non-destructive cleaning method.

WELDROD: To be used for normal repairs, our ECOMold[®] Weld Wire.

- Available from ECOMold Products in 1/16 Diameter x 36" Length bare wire electrode and also .047 Diameter one pound coil stock.

ECOMold[®] Weld Rod has shown to be the product of choice to repair all ECOMold[®] alloys, copper nickel alloys, and Beryllium copper alloys. **HARDNESS** level is reasonably close to parent material where applied. Excellent color match with no sink at edges of weld zone.

Alternate Weld Materials:

- 420 Stainless
- 17-4PH Stainless (for hardness)



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*Welding Recommendations courtesy of
Performance Alloys & Services, Inc.*