

## MIDAS® - M2

Shielded Metal Arc Welding  
(SMAW-Stick)

For high speed tool steels

## MIDAS® - H12

Shielded Metal Arc Welding  
(SMAW-Stick)

For hot and cold working tool steels.

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### FEATURES M/M-2

- Hardness 64 RC
- Durable cutting edge
- Pierce blank dies
- Broaches, knives, shears
- Excellent friction resistance

### FEATURES M/H-12

- Hardness 59 RC
- Wide temperature range
- Wear and cutting surface
- Oil, air and water hardening
- Abrasion and shock resistant

### CHARACTERISTICS

**MIDAS-M2** is outstanding for cutting edges. Rebuilt areas resist wear and make salvage possible on expensive tools. Repairs with **MIDAS-M2** are simple and economical. New cutting edges and overlays often out-perform base metal. Air hardens after welding.

**MIDAS-H12** has been developed for cutting edges and abrasion surfaces over a wide range of temperatures. Deposits respond to heat treatment like the base metal. Outstanding results are obtained on hot cavities or surfaces that heat extensively during work, such as mandrels. Air hardens after welding.

### APPLICATION

Apply with medium heat, stringer beads. Avoid color in base metal. Peen and preheat to 500°F (260°C) on larger or complex parts. Use **BRUTUS-A** as an ideal cushion layer.

### TECHNICAL

Size and Amps AC/DC  $\pm$  20%

Inches:	3/32	1/8
(mm):	(2.4)	(3.2)

Amps:	70	95
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With DC use reverse polarity. (DCEP)

