

# MIDAS® - M2 TIG

Pink Tip

Gas Tungsten Arc Welding  
(GTAW)

# MIDAS® - H12 TIG

Orange Tip

For high speed tool steels.

For hot and cold working tool steels.

## FEATURES - M2

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

## FEATURES - H12

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

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## 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 the 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

Clean base metal completely. Remove all fatigued metal and round sharp edges. Establish arc on copper starting block, carry over to base metal. Add filler metal when puddle forms. Each deposit of filler metal must flow before continuing. Fill all craters. Pre and post heat may be necessary. Use DC straight polarity with argon for shielding.

Sizes:

Inches:	.035	.045	1/16	3/32	1/8*	(DCEN)
(mm):	(0.9)	(1.2)	(1.6)	(2.4)	(3.2)	

**\*MIDAS-H12 TIG only.**