

# Midas<sup>®</sup> M2

## Shielded Metal Arc Welding (SMAW – Stick)

For high speed tool steels.

### Features

- Hardness 64 RC
- Durable Cutting Edge
- Pierce Blank Dies
- Broaches, Knives and Shears
- Excellent Friction Resistance

### 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.

### Technical

Size and Amps AC/DC ±20%

Inches	3/32	1/8
(mm)	(2.4)	(3.2)
Amps	70	95

With DC use reverse polarity. (DCEP)

### Application

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

# Midas<sup>®</sup> H12

## Shielded Metal Arc Welding (SMAW – Stick)

For hot and cold working tool steels.

### Features

- Hardness 59 RC
- Wide Temperature Range
- Wear and Cutting Surface
- Oil, Air and Water Hardening
- Abrasion and Shock Resistant

### Characteristics

**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.

### Technical

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

Inches	3/32	1/8
(mm)	(2.4)	(3.2)
Amps	70	95

With DC use reverse polarity. (DCEP)

### Application

- Apply with medium heat, stringer beads.
- Avoid color change in base metal.
- Peen and preheat to 500°F (260°C) on larger or complex parts.
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