ROCKMOUNT
Welding Alloys

Midas® M2 TIG

Gas Tungsten Arc Welding (GTAW)

For high speed tool steels.

Features

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

Characteristics

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

Technical

Inches	.035	.045	1/16
(mm)	(0.9)	(1.2)	(1.6)

(DCEN)

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.

Identification

- Marked by **Pink Tip**

ROCKMOUNT
Welding Alloys

Midas® H12 TIG

Gas Tungsten Arc Welding (GTAW)

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 TIG 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

Inches	.035	.045	
(mm)	(0.9)	(1.2)	

Inches	1/16	3/32	1/8
(mm)	(1.6)	(2.4)	(3.2)

(DCEN)

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.

Identification

- Marked by **Orange Tip**