

SGT Welding Die Matching Chart

SGT manufactures industry standard dies for wire sizes between 0.10 mm and 25.0 mm, manufactured to suit round or profile wires and rods according to the customer's specifications. SGT dies are also suitable for comparable cold pressure welders from other manufacturers.

Die	Matched Machines	Copper Wire	Aluminium Wire
SD1 single cavity	PB10, PC10, PW10	0.10 mm – 0.50 mm	0.10 mm – 0.50 mm
SD2 double cavity	PA30, DA30, DB30	0.30 mm – 1.20 mm	0.30 mm – 1.40 mm
Single cavity	DA100, DB100	1.00 mm – 3.25 mm	1.00 mm – 5.00 mm
Double cavity	DA100, DB100	1.00 mm – 2.50 mm	1.00 mm – 2.50 mm
CHY100 dies	CHY100 hydraulic welder	1.00 mm – 4.00 mm	1.00 mm – 6.00 mm
CHY200 dies	CHY200 hydraulic welder	2.00 mm – 5.00 mm	2.00 mm – 8.00 mm
CHY400 dies	CHY400 hydraulic welder	4.00 mm – 8.00 mm	4.00 mm – 14.00 mm
CHY700 dies	CHY700 hydraulic welder	7.00 mm – 13.00 mm	7.00 mm – 25.00 mm

The range for rectangular non-ferrous wire is calculated from the cross-sectional area.

Die Tolerance

The tolerance held between the wire and the welding die is -1% to +2% of the wire diameter. Special welding dies can be manufactured to weld two different wire sizes together according to the customer's requirement.

Drawing and Extrusion Tooling

Tooling	Material	Size Range
Tungsten carbide dies	Tungsten carbide	0.015 mm - 32.0 mm
PCD dies (wire drawing)	Polycrystalline diamond	0.03 mm - 20.00 mm
PCD dies (cable stranding)	Polycrystalline diamond	0.50 mm - 40.00 mm
Nano dies	Nano diamond coating	0.50 mm - 120 mm
Extrusion tips	Carbide or diamond insert	0.050 mm - 12.50 mm
Extrusion tips	Stainless steel	0.50 mm - 25.0 mm
Quartz welding crucible	Quartz glass	hole 0.300 mm - 8.200 mm

To order, state the machine model and the exact wire diameter and profile. Contact info@coldweldingmachine.com or WhatsApp +86 186 7650 2819.