

## DIFFUSALOY 618 X

A highly austenitic 'LoTemp' high recovery electrode for joining and overlaying Manganese steels and joining these to other steels. Weld deposits have excellent resistance to heat and mild corrosion. Alloy exhibits exceptional all positional weldability, easy slag detachability and very high crack resistivity.

### Applications :

For the positional joining and repair of manganese steel parts used in construction, earthmoving and mining industry such as crushers shovel, excavator and dragline buckets, sprockets, track pads and mantles etc. Can be used for joining manganese steel to other steels and for joining armour plates.

### Procedure:

Degrease to remove oil and grease. Gouge out/grind small cracks, damaged and fatigued metals. Use AC/DC + power source. Set lowest possible welding current within the range. Hold short arc and employ short, stringer beads. Use skip and staggered welding sequences. Chip slag between passes. On manganese steel, do not allow base metal temperature to go beyond 250 °C. Preheat is usually not necessary unless very heavy sections are involved.

<b><u>Technical Data</u></b>	:	<b>DIFFUSALOY 618X</b>		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	90 – 125	110 – 160	140 - 190
Tensile Strength	:	65 kgf / mm <sup>2</sup>		
Elongation	:	30 – 40 %		
CVN Impact Strength at 27 <sup>0</sup> C	:	10 Kgfm/cm <sup>2</sup>		
Tip Colour	:	Deep Green		

### DIFFUSION ENGINEERS LIMITED

Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085

Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036

Works III : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984

Email : info@diffusionengineers.com Website : www.diffusionengineers.com

Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.