

DIFFUSALOY 618

A new highly alloyed austenitic 'LoTemp' electrode for joining and overlaying manganese steels and for joining these to other steels. This has exceptional all positional weldability, easy slag detachability and excellent crack resistivity.

Applications :

For positional joining and repair of manganese steel parts used in construction, Earthmoving, Defence and mining industry such as shovel, excavator and dragline buckets, sprockets, track pads and crushers. Recommended as a buffer layer on manganese steels prior to antiwear, coating.

Procedure:

Degrease to remove oil and grease. Gouge out/grind 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 alloy base metal temperature to go beyond 250 °C.

<u>Technical Data</u>	:	DIFFUSALOY 618		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	60 – 100	100 – 160	140 - 190
Tensile Strength	:	65 kgf / mm ²		
Elongation	:	30 – 40 %		
Coating colour	:	White		
Tip Colour	:	Deep Green		

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