

DIFFUSALLOY 68

Newly formulated heavy coated, high recovery electrode designed specially for extreme abrasion resistance at high temperature. Alloy is easy to handle with rapid deposition rate leaving very little or no slag. Deposits consist of high percentage of primary chromium carbide and secondary vanadium carbides and Borides for optimum results. Hardness is retained up to 600⁰ C.

Applications:

For use in still mills and sinter plants , On items such as Crusher sieves, Conveyor screws , Dredger components and Tip casting.

Procedure:

- i Remove damaged , Oxidized and fatigued metal.
- ii Use AC/DC + Power sources.
- iii Maintained short to medium arc.
- iv Use stringer , slightly weave bead.
- v For high carbon steel base metal preheated to 250⁰ C . Slow cool after welding.

Technical Data

: **DIFFUSALLOY 68**

Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	95 - 130	130 – 170	160 –200
Hardness	:	61 – 66 HRC		
Tip Colour	:	Golden Brown		

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