

## TUFALOY 1200 X

A unique high strength, high ductility anti wear low Temp electrode designed and developed with stainless steel core wire for yielding ideal chemistry of weld deposit, for best results. The specially selected core wire Chemistry and the Coating formulation yields weld deposits, which are highly crack resistant matrix and is an ideal answer for build up and overlay on manganese steel and railway points and crossings. The deposit is fully austenitic and free from inter-granular carbides and is very ductile and capable of taking very heavy impact loads, rolling friction and abrasion.

### Applications:

For very heavy impact applications, crusher and excavator equipment, railway points and crossings, switches, mill hammers, blow bars etc.

### Procedure:

Gouge out and grind fatigued base metal . Use short and stringer beads. Base metal cooling necessary during welding to eliminate likely carbide formation and embrittlement. The job to be welded should not exceed temperature of 200<sup>0</sup> C. It is preferable to chill the weld as soon as welds are laid. Hot penning of weld bead, is beneficial to convert tensile stresses to compression stresses. Electrode is capable of running on AC/DC+.

### Technical Data

Size (mm) Dia	:	3.15	4.00	5.00
Current (Amps)	:	100-130	130-170	150-220
Hardness as deposited	:	200 - 250 BHN		
Hardness after Work Hardened	:	450 –500 BHN		
Microstructure	:	Fully austenitic.		
Deposition Efficiency	:	115% Min.(Core wire method)		

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