

TUFALOY 3200

Specially formulated electrode for complexities of wear. Deposits withstand moderate impact and medium to high abrasion and retain hardness upto 500°C. Ideally suited for hot forging dies, pinion teeth (final layer), Coal burner tips etc. Also suitable for general corrosion and heat-resistant applications.

Applications:

Welding and overlaying of parts of turbines, cast chromium valve bodies, pump parts, oil refinery equipment ,coal washeries burner pipes, hot forging dies, mill pinions, earth moving machinery tumblers etc.

Procedure:

Pre-heat electrode at 200°C for one hour is recommended before use.

Grind worn out and fatigued metal.

Clean weld area. Clamp and tack weld at short intervals.

Use electrode on AC/DC + at the lowest amps.

Relieve stress at 580°C, 620°C if necessary.

<u>Technical Data</u>	: TUFALOY 3200			
Size (mm)	: 2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	: 60 – 90	90 – 120	120 – 140	140 - 170
Tensile Strength	: 100 kgf / mm ² (Min.)			
Elongation	: 14-16% (Min.)			
Hardness (As deposited)	: 275 BHN			
(Work hardened)	: 375 BHN			
Tip Colour	: Golden Brown			

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