

UNILOY 620

A 'Lo Temp' electrode with high alloy formulation for joining and overlaying medium and high carbon steels. Specially recommended for restrained joints and for joining carbon steels to stainless steels. Deposits offer high tensile strength, ductility, heat and corrosion resistance.

Applications:

Track pad, furnace parts, bucket repair, cooler plates, apron feeder pan, steel gears, for cladding stainless steel etc.

Procedure:

Degrease to remove oil and grease. Gouge out/grind crack and damaged/worn/fatigued metal. Use electrodes on AC/DC+. Hold short arc and employ short and skip welding sequence. Use staggered welding and stringer beads. Chip slag between passes. Peen deposit while hot. Preheat is not necessary unless very heavy section are involved.

<u>Technical Data</u>	:	UNILOY 624			
Tensile Strength	:	68 kgf/ mm ²			
Hardness	:	160-180 BHN			
Elongation	:	30%			
Coating Colour	:	Light Blue			
Tip Colour	:	Light YELLOW			
Size (mm), Ø	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	50-90	60-110	100-140	130-180

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.