

UNILOY 624 S

A versatile high alloyed 'Lo Temp' electrode with superior weldability, designed for joining dissimilar steels. Can also be used for machinable buildup or a cushion layer. The controlled grain structure provides the deposit with high strength, ductility, toughness and superior crack resistance. The deposit is corrosion resistant as well.

Applications:

For combinations of similar and dissimilar steel and joining of different sections. Can be used for dies, tools, springs, buildup on steel castings for repairs, for joining wear plates, cushion layers for hard facing etc.

Procedure:

Gouge/grind out cracks, damaged, fatigued metal. Use skips and staggered welding. Peen deposits while hot. Preheat is usually not required unless very heavy section are involved.

<u>Technical Data</u>	:	UNILOY 624			
Tensile Strength	:	85 kgf/ mm ²			
Hardness	:	220 BHN			
Size (mm), Ø	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	45-90	60-110	100-150	140-190

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