

DIFFUSALOY 565 CrNi

This is a specially developed basic electrode, which gives a highly alloyed weld metal which exhibits an excellent combination of moderately high hardness, toughness, corrosion resistance to various aqueous solutions. It is an ideal choice where moderate wear resistance under moderate impact stress is required in a corrosive media.

Applications:

Ideally suitable for resisting humid corrosion, abrasion and moderate impact. Typical examples are – Build up of Sugar Mill Crusher Rollers of cast iron which gets chipped off during service. Slurry Pump Casings, Impellers and other cast iron components. On cast irons, first and second layers of the deposit are machinable.

Procedure:

Remove all fatigued material by gouging or grinding. Heat the base metal at 200-300°C depending upon size and thickness of the component. Use stringer beads and short arc procedure. Weaving should be limited to 2.5 times diameter of the electrode.

<u>Technical Data</u>	:	DIFFUSALOY 565 CrNi		
Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	85 - 120	105 – 140	125 –165
Hardness	:	On M.S	On Cast Iron	
Third Layer	:	41 - 43 RC	48 - 50 RC	
First Layer	:	42 - 45 RC	18 - 25 RC	
Tip Colour	:	Yellow		

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