DIFFUSALOY 628

A unique low heat input ‘Low temp’ electrode specially designed for joining and over–laying on medium carbon steel, low and high alloy steels, stainless steels and silicon steels (laminations). Deposit exhibits high tensile strength, ductility, heat and corrosion resistance.

Applications:

Specially recommended for Super-conditioning of sugar mill roller journals subjected to friction and corrosion as direct deposit or as overlay on Supermatic for heavy build-up. Recommended for welding of silicon steel stampings.

Procedure:

1) Gouge out/grind cracks, damaged, worn, and fatigued metal.
2) Use the electrode on AC/DC+ power source.
3) Employ short stringer beads.
4) Use skip and staggered welding sequence.
5) Chip slag between passes. Peen the deposits while hot.
6) Preheat is usually not required unless very heavy sections are involved.

Technical Data : DIFFUSALOY 628

Size (mm), Ø : 2.5  3.15  4.00  5.00

Recommended Welding Current (Amps) : 60 - 90  75-100  100 –150  140 - 190

Tensile Strength : 60 kgf/ mm²

Elongation : 25-30 %

Hardness : 160-190 BHN

Tip Colour : GREEN