DIFFUSALOY DIE 105

DESCRIPTION:

DIFFUSALOY DIE - 105 is a newly developed electrode with Cr-W-V used for similar type steel and also for overlaying the edges or surfaces of tools made of low alloyed steels. The Tungsten special addition makes the weld deposit suitable for edge retention property. Weld deposit have good high temperature resistance which is very helpful in increasing the life. This product is very much suitable for forging die repairs in forging industry.

APPLICATIONS:

DIFFUSALOY DIE - 105 is used for hot shear blades, drawing blocks, hot forging dies, impact moulding dies, slab shears, containers, swages etc.

PROCEDURE:

Remove damaged, Oxidized and fatigued metal. Use AC/DC + Power sources. Maintained short to medium arc. Use stringer, slightly weave bead. Maintain preheat and interpass temperature between 350 °C and 450°C as per the base metal. The above temperature should be chosen for thick work pieces. Peening of deposit is essential. Slowly cool down the job in sand or oven.

TECHNICAL DATA : DIFFUSALOY DIE - 105

Size (mm), Ø : 3.15 4.00 5.00

Recommended Welding Current (Amps) : 80 - 120 120 – 150 150 – 190

Hardness : 47 – 54 HRC

Tip Colour : Grey