

XALOY 52

A highly low amp anti-wear electrode for overlaying, cushioning and building up low, medium carbon, low alloy and Hadfield steels. Deposits are extremely tough and resist deformation under repeated pounding/impulsive loads. Deposits rapidly work-harden during impact service condition.

Applications:

A unique two-in-one electrode, first of its kind, developed exclusively for repair of railway points, crossing switches. Other applications include mill hammers, crusher mantles and shredder hammers.

Procedure:

- 1) Gouge out/ Grind worn and fatigued metal.
- 2) Use AC/DC+ power source.
- 3) Employ short, stringer beads, chip slag and peen deposits while hot.
- 3) Do not allow manganese steel interpass temperature above 250⁰ C.

Technical Data

Size (mm), Ø	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	100 - 120	120 – 160	150 – 200
Hardness (as deposited)	:	22 – 25 HRC		
Hardness (work hardened)	:	45 – 50 HRC		
Tip Colour	:	Ivory		

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.