

DIFFUSALLOY DIE 105

DESCRIPTION:

DIFFUSALLOY 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:

DIFFUSALLOY 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 350⁰ C and 450⁰ 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	:	DIFFUSALLOY 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		

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