

DIFFUSALLOY DIE 100

DIE - 100 is a newly developed electrode with Cr-Ni-Mo specially for forging die – repairs in forging industry. The deposited weld metal is highly resistant to cracking even with higher impact load. It is used for welding high-strength tempered low-alloy steels as well as process welding on steels castings, cast steels of corresponding strength.

Applications:

DIE - 100 is an all position electrode with high strength for repair of large forging dies, hot working tools, hammer bases, sow blocks anvil, devotails and insert dies, rolls of cold rolling mill. Any surface requires impact and friction resistance.

Procedure :

- i Remove damaged , Oxidized and fatigued metal.
- ii Use AC/DC + Power sources.
- iii Maintained short to medium arc.
- iv Use stringer , slightly weave bead.
- v For high carbon steel base metal preheated to 250⁰ C .
- vi Air cool the job for better hardness. Peening of deposit is essential.

<u>Technical Data</u>	: DIFFUSALLOY DIE - 100		
Size (mm), Ø	: 3.15	4.00	5.00
Recommended Welding Current (Amps)	: 80 - 120	120 – 150	150 –190
Hardness	: 42 – 45 HRC		
Tensile Strength	: 75 kgf/ mm ²		
Tip Colour	: Grey		

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