

DIFFUSALLOY DIE 101

DIFFUSALLOY DIE - 101 is a newly developed electrode with Cr-Ni-Mo-W-Co specially for forging die – repairs in forging industry. The special alloy addition makes the weld deposit suitable for using where higher level of strength, toughness and ductility is required. Weld deposit have good high temperature resistance which is very helpful in increasing the Die life. The deposited weld metal is highly resistant to cracking even with higher impact load and temperature. 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:

DIFFUSALLOY DIE - 101 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 - 101		
Size (mm), Ø	: 3.15	4.00	5.00
Recommended Welding Current (Amps)	: 80 - 120	120 – 150	150 –190
Hardness	: 37 – 42 HRC		
Tensile Strength	: 115 kgf/ mm ² (min.)		
Tip Colour	: Grey		

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