

DIFFUSALOY 628

A unique low heat input 'Low temp' electrode specially designed for joining and over-laying on medium carbon steel, low and high alloy steels, stainless steels and silicon steels (laminations). Deposit exhibits high tensile strength, ductility, heat and corrosion resistance.

Applications:

Specially recommended for Super-conditioning of sugar mill roller journals subjected to friction and corrosion as direct deposit or as overlay on Supermatic for heavy build-up. Recommended for welding of silicon steel stampings..

Procedure:

- 1) Gouge out/grind cracks, damaged, worn, and fatigued metal.
- 2) Use the electrode on AC/DC+ power source.
- 3) Employ short stringer beads.
- 4) Use skip and staggered welding sequence.
- 5) Chip slag between passes. Peen the deposits while hot.
- 6) Preheat is usually not required unless very heavy sections are involved.

<u>Technical Data</u>	: DIFFUSALOY 628
Size (mm), Ø	: 2.5 3.15 4.00 5.00
Recommended Welding Current (Amps)	: 60 - 90 75-100 100 –150 140 - 190
Tensile Strength	: 60 kgf/ mm ²
Elongation	: 25-30 %
Hardness	: 160-190 BHN
Tip Colour	: GREEN

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