

## DIFFUSALOY 817

Specially formulated, unique, highly alloyed electrode for overlay buildup and repair of worn out parts subject to oxidation, corrosion and thermal/mechanical stresses at high temperatures. Deposits are tough, crack free and work hardening type. Heavy coated electrode having metal recovery of 150%.

### Applications:

Hot forging dies, Hot trimming dies, restoring cutting edge of hot cutting and shaping tools, valve seats.

### Procedure:

Clean weld area. Remove all cracks and fatigue material. Maintain low interpass temperature and medium arc. Chip slag between passes. Use stringer beads when welding dissimilar metals. Re-drying upto 100<sup>0</sup>C for one hour is beneficial.

<b><u>Technical Data</u></b>	<b>: DIFFUSALOY 817</b>		
Size (mm)	:	3.15	4.0      5.0
Recommended Welding Current (Amps)	:	100 – 140	140 – 170      170 - 210
Tensile Strength	:	45 kgf/ mm <sup>2</sup> Min.	
Elongation (l = 4d)	:	30% Min.	
Hardness (As Deposited)	:	19 – 24 HRC	
(Work Hardened)	:	38 – 43 HRC	

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