

SUPERALLOY 1755 MO

DESCRIPTION:

Superalloy 1755 MO is a basic coated electrode which yields an inconel type deposit that does not require any special post weld heat-treatment to develop its optimum properties, and at the same time, sustains any post weld heat treatment that is necessary. The weld deposit possesses an excellent ability to resist oxidation and wear at high temperature its high strength coupled with high ductility and good creep and heat resistance at high temperature (550-1100 °C) makes it automatic choice for high temperature applications. Thermal stability of the weld deposit is a key feature that makes it able to with stand stresses developed due to the thermal shock and thermal cycling.

APPLICATIONS:

Joining of various types of stainless steels, Ni-base alloys, dissimilar joints, especially austenitic to ferritic steel, Welding of weld cladding on low alloy steels, reactor vessels, welding of joints in nuclear engineering, welding of cryogenic steel, antiwear and anticorrosion surfacing of furnace components, heat treatment furnace and fixtures, making transition joints, gate valves in freaon gas plants, and similar applications. The deposit does not chip or spall and resists cracking. Because of its excellent resistance to impact and heat, it is exceptionally suitable for hardfacing components which require high wear resistance under impact, like hot forging dies. The deposit retains its high hardness and strength even at elevated temperature.

PROCEDURE:

Clean weld area. Remove fatigued metal. Preheat is not necessary, unless very heavy sections are involved. It can be used with a short arc or as a contact electrode.

TECHNICAL DATA	:	SUPERALLOY 1755 MO		
Size (mm)	:	2.5	3.15	4.0
Recommended Welding Current (Amps)	:	60 - 90	90 – 120	130 - 160
Tensile strength	:	60 kgf/mm ²		
Tip colour	:	Silver		

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