

TUFALOY 320

A low heat input "Anti-Wear" alloy steel electrode, for tough, machinable and wear-resistant build-up and overlay on low and medium carbon, low & medium alloy steels cushioning prior to capping with harder abrasion-resistant deposits. Tufaloy 320 deposits an alloy chemistry which resist wear due to high impact followed by mild abrasion and friction. Deposits can be induction / flame hardened.

Applications:

Sprockets, carrier and track rollers, idlers of earth moving equipments, crane wheels, pinions and gears, tail bars, wobbler ends of rolls and couplers in steel plants and sugar mills, girth gears of cement mills and power stations and supporting rollers of kiln tyres.

Procedure:

Degrease to remove oil and grease. Gouge out/grind cracks and damaged, worn, fatigued metal. Use electrode on AC / DC +. Hold medium arc. Electrode can be weaved 1.5 to 2 times its diameter. Chip slag between passes. Peen deposits while hot. Preheat is usually not necessary unless very heavy sections are involved.

<u>Technical Data</u>	:	TUFALOY 320		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	80-110	120 – 150	150 – 200
Hardness (As Deposited)	:	28 – 32 RC		
Hardness (Flame Hardened)	:	35 – 40 RC		
Coating Colour	:	Grey		
Tip Colour	:	Light Grey		

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