

UNILOY 608

A unique low heat input electrode with superior alloy formulation, for high strength joining and cushioning of medium and high carbon steels, tool and die steels, stainless steels, tool and die steels, stainless steels, and stainless to carbon steels. Also recommended for overlays on carbon steels for corrosion resistance and high temperature service upto 1100 C.

Applications:

Parting tools, joining Hadfield steels parts in earth – moving machinery, track pads, furnace parts, cooler plates, sugar mill roller journals etc.

Procedure:

Gouge out / grind all damage, worn, fatigued metal/cracks. Use the electrode on AC/DC+. Hold short arc. Employ shorts, skip welding sequence with staggered and stringer weld beads.

<u>Technical Data</u>	:	UNILOY 608			
Size (mm), Ø	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 - 90	60 – 110	110 –140	140 - 190
Tensile Strength	:	68 kgf/ mm ²			
Hardness	:	160-190 BHN			
Elongation	:	30 %			
Tip Colour	:	Deep Orange			

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