

UNILOY 624

A unique high alloyed low heat electrode for high strength, crack resistant joining of unknown and dissimilar steels, Hadfield, high carbon and alloy steels. Also recommended for tough and wear resistant overlays on all steels. Controlled ferrite austenite duplex structure provides resilience with very high strength.

Applications:

Used for splines, threads, keyways of shafts, spur gear tooth, wear plates of hydraulic excavator buckets, gear box main shafts, counter shafts, leafsprings etc.

Procedure:

- 1) Gouge out/grind, worn, damaged and fatigued metal/cracks.
- 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>	:	UNILOY 624			
Size (mm), Ø	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 - 90	80 – 110	110 –150	140 - 190
Tensile Strength	:	85 kgf/ mm ²			
Coating Colour	:	Blue			
Tip Colour	:	YELLOW			

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