

Suitable to Join High Alloy Steels Subjected to Thermal Cycling and Joining Without Effects of HAZ

Typical Applications :

Maintenance and repair of high alloy steels subjected to cryogenic & thermal cycling, joining & repair of heavily restrained and massive sections, draw bars & connecting hitches, tongs, flame hardening equipment, heavy cross sections gears, furnace parts, kiln tyres.

Outstanding Features :

- Excellent crack resistance, unaffected by base metal dilution
- Suitable for both high temperature service / thermal cycling and subzero service
- Exceptional combination of tensile properties and impact strength
- Excellent oxidation and scaling resistance
- No effects on heat treatment

Welding Procedure:

Ensure welding surfaces are free from contaminations. For steels with carbon equivalent to above 0.45% preheating between 150°C to 300°C is necessary. Operate at lowest possible current setting. Weld with short arc and stringer beads avoid weaving, chip slag between passes & peen. Use stainless steel wire brush to remove slag residues.

Recommendations :

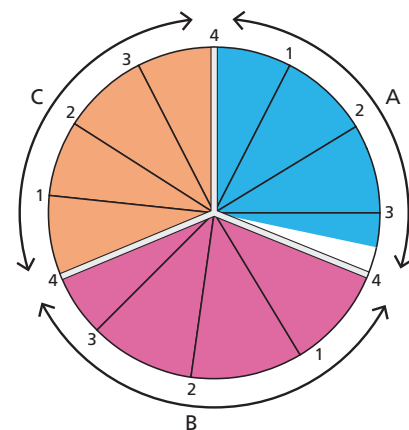
For joining & overlaying of high alloys subjected to thermal cycling or wide temperature range. Recommended for joining where PWHT is 100% not possible. Can be recommended for welding high section thickness without HIC.

Tensile Strength : 65 kg/mm² (92,000 psi)

Elongation : 45%



Kiln Tyre Crack Repair



- A - Mechanical strength 3½
- B - Ductility 4
- C - Versatility 4

Recommended Amperage:

Size (mm)	I - Range	II - Range
2.50	60 - 80	50 - 70
3.15	80 - 100	70 - 90
4.00	110 - 130	90 - 110

