

DIETHERME-HD

CHARACTERISTICS AND APPLICATIONS :

A hardfacing electrode depositing low hydrogen, low alloy steels weld metal for surfacing hammer dies. The weld metal possesses good toughness and resistance to heat for enhancing the life of the dies.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Cr	Ni	Mo	V
Percent :	0.08	1.45	0.42	2.20	2.10	0.95	0.30

WELD METAL HARDNESS (on 3 LAYERS) after SR 560^o C for one hour: 35-38 RC

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	: 8x450	6.3x450	5x450	4x450	3.15x450
Dia x Length					
Current Range (Amps)	: 300-350	270-320	200-250	150-180	100-130
Weight/Carton (kgs)	: 5	5	5	5	5

PRECAUTIONS:

1. The electrodes should be dry. Redry the moist electrodes at 250°C for one hour.
2. When welding on high hardenable materials of large thicknesses, adequate care for preheating, slow cooling & PWHT are necessary.
3. Use short arc and minimum weaving.