

## DIFFUSALOY 555

A newly developed basic coated electrode designed to give a highly alloyed weld metal. The weld metal is machinable and exhibits a high degree of toughness. Excellent for hot strength and wear resistance at elevated temperature and also it stands for against temperature shocks, and it has an excellent creep resistance properties.

### Applications:

Extremely suitable for building up large composite dies or extensive repair of similar dies found in steel, chemical industries, cryogenic as well as nuclear industry.

### Procedure:

Remove all fatigued material by gouging or grinding. Heat the base metal at 200-300°C depending upon size and thickness. Use stringer beads and short arc procedure. Weaving should be limited to 2.5times diameter of the electrode. Diffusaloy 555 is capable of developing secondary hardening and hardness can be controlled between 38-44 HRC, by tempering at 550°C.

<b><u>Technical Data</u></b>	:	<b>DIFFUSALOY 555</b>		
Size (mm)Dia	:	3.15	4.00	5.00
Welding Current (Amps)	:	85 – 120	105 – 140	125 - 165
Tensile Strength	:	115 kgf / mm <sup>2</sup>		
Hardness	:	48 – 52 HRC		
Tip Colour	:	Yellow		

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