

GRELOY 850

A truly low heat input 'Lo Temp' application – designed for filling, joining and building up grey cast iron and malleable iron, without preheat. Also for joining these to steels. Greloy 850 is a high-Nickel alloy electrode, producing dense and smooth deposits of high strength and superior machinability.

Applications:

Recommended for all types of repairs on cast iron machine bases, cylinder blocks, motor/generator/pump casings, impellers, machine slides etc. Excellent for filling up foundry defects. Ideal for repair and production joining of cast iron to steel.

Procedure:

Gouge / grind out cracks to prepare beveled edges. Use the electrode on AC / DC – at lowest amperage. Deposit short, stringer beads with short arc. Peen the weld deposits while hot. Complete repairs at hand heat. Preheat is usually not necessary unless very heavy sections are involved.

<u>Technical Data</u>	:	GRELOY 850			
Electrode size (mm), Ø	:	2.5	3.15	4.00	5.00
Welding current (AMPS)	:	45-75	65-110	80-130	100-170
Tensile strength	:	upto 35 kgf/mm ²			
Coating Colour	:	Black			
Tip colour	:	Pale Cream.			

DIFFUSION ENGINEERS LIMITED

Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085

Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036

Works III : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984

Email : info@diffusionengineers.com Website : www.diffusionengineers.com

Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.