

DUROCHROME

Dissimilar and unknown steel strength joining

Esab Durochrome is an electrode for welding complex dissimilar alloys and high strength steels with low heat input giving sound joints, free from any cracks and fissures. The electrode is also suitable for depositing buffer layers prior to hard surfacing on high strength and high alloy steels.

The deposit is corrosion resistant and resists high temperature oxidation. It provides excellent metal to metal frictional resistance.

ALLOY BASE: Fe, Cr, Ni, Mn

SPECIAL FEATURES

- Operates at low amperages on both AC & DC.
- Smooth arc, fine ripples and easily detachable slag.
- The duplex structure steel weld metal is extremely tolerant to dilution.

APPLICATIONS

Welding of high strength alloy steels, dissimilar joints, rebuilding of chemical agitator blades, shafts, rolling mill spindles, bucket lips, steel mill wobblers, coupling boxes, mill hammers, bar mill guides, sinter plant parts, etc.

Joining and surfacing of high carbon, low and high alloy steels, tool steels, spring steels, manganese steels, case hardening steels, etc.

PROPERTIES

UTS : 77-82 kg/mm²

Elongation : 30-35%

CURRENT RANGE : (AC 70, DC±)

Size (mm)	Length (mm)	Current Range (Amp)
2.50	350	40-65
3.15	350	55-95
4.00	350	85-135
5.00	350	110-165