

## **TERROWELD DS1**

### **Crack free joining and buffering of manganese steel**

Terroweld DS1 provides a manganese alloyed chrome - nickel steel deposit having high resistance to hot cracking with low heat input. It is ideally suited for joining manganese steel to carbon steel and for buffer layer deposition on manganese steel. Being able to withstand heavy impact, corrosion and moderate abrasion, this electrode can be used for build-up layers on high strength high alloy steel.

**ALLOY BASE:** Fe, Cr, Ni, Mn

### **SPECIAL FEATURES**

- Weld metal is resistant to hot cracking.
- Slag is easily detachable.

## **APPLICATIONS**

Joining and reinforcing of manganese steel components, joining of dissimilar steels, buffer layer prior to hard surfacing of crusher jaws, bucket teeth, sprockets etc.

## **PROPERTIES**

UTS : 54-62 kg/mm<sup>2</sup>

Elongation : 38-42%

## **CURRENT RANGE : (AC 70, DC±)**

Size (mm)	Length (mm)	Current Range (Amp)
2.50	350	60-90
3.15	350	70-110
4.00	350	100-130
5.00	350	110-150