

## TERROWELD DBL

### Super ductile joining and buffering

Terroweld DBL deposits a high strength low alloy weld metal recommended for building up and joining of low, medium carbon and low alloy steels. It is also suitable for giving buffer layers on medium and high carbon steels prior to hard surfacing.

The weld deposit is extremely ductile and crack resistant. Produces excellent result in highly constrained heavy machinery joining.

Low heat formulation suitable for joining thin section without risk of burn-through.

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

### SPECIAL FEATURES

- Super-ductile weld.
- Suitable for high speed welding.
- Bonds easily with parent metal.

### APPLICATIONS

Joining and build-up of medium tensile steels, joining dissimilar sections, restrained joints, giving buffer layers on pipes, flanges, pressure vessels, cross members, gun plates, steel castings, heavy machine components, etc.

Perfect in welding steels like free-cutting steels, where sulphur and other alloys are added.

### PROPERTIES

UTS : 52-55 kg/mm<sup>2</sup>

Elongation : 28-32%

### CURRENT RANGE : (AC 50, DC±)

| Size (mm) | Length (mm) | Current Range (Amp) |
|-----------|-------------|---------------------|
| 3.15      | 450         | 90-135              |
| 4.00      | 450         | 140-165             |
| 5.00      | 450         | 170- 220            |

| Size (mm) | Length (mm) | Current Range (Amp) |
|-----------|-------------|---------------------|
| 3.15      | 350         | 90-135              |
| 4.00      | 350         | 140-165             |
| 5.00      | 350         | 170- 220            |