

SPECIAL ALLOYS FOR MAINTENANCE & REPAIR

ELECTRODES

For High Temperature & Special Applications

PRODUCT GOLD : 520



Descriptions	Technical Details	Ømm	List Price
Universal high nickel maintenance electrode for welding nickel alloys, dissimilar steels, high temperature steel, (Incoloy 800) cryogenic stainless steels tool steel etc. 520 is the most versatile electrodes for all difficult weld repairs. For weld repairs in Power stations, steelworks, chemical industries	Rm (Mpa) : 680	3.2	
	Re (Mpa) : 420	4.0	
	A5 (%) : 40		
	Hardness : ~220, 240 HB Temperature Resistance: > 1200°C		

ELECTRODES

For Non Ferrous Metal Overlaying-Prestress

PRODUCT GOLD : 610



Descriptions	Technical Details	Ømm	List Price /kg
ELECTRODE FOR ALUMINUM Use for repairs and joining of Al Plates, sheets, pipes, extrusions etc. Applications include al, engine blocks, cylinder heads, boats construction, housings, pumps, tanks, moulds, frames, truck bodies, bus bars etc.	Rm (Mpa) : 180	2.6	
	Re (Mpa) : 80	3.2	
	A5 (%) : 6	4.0	
	Weld metal compositions : AL + Si		

PRODUCT GOLD : 620



Descriptions	Technical Details	Ømm	List Price /kg
Maintenance electrode with a complex Cu-bronze deposit for joining and surfacing of copper-alloys, steel and cast iron also for dissimilar joints between copper alloys and steels. The deposit is corrosion, seawater and cavitations resistant with a low coefficient of friction. Used in ship building , for pumps, impellers, propellers, screws, for surfacing of shafts, bearings, hydraulic piston heads, cable guides and machinery parts, automotive forming dies etc. Excellent for protection of parts against metal-metal wear. As a overlay for deep drawing of mild steel, stainless steel, aluminium and titanium	Rm (Mpa) : 660	2.6	
	Re (Mpa) : 420	3.2	
	A5 (%) : 22	4.0	
	Hardness : ~220 HB		
	Weld metal composition : Cu, Mn, Ni, Al		