

DIFFUSALLOY GZB LH

Diffusaloy GZB-LH is a specially developed electrode with a unique coating that makes it possible to deposit a weld metal which is almost pure iron, containing very little silicon and carbon and quite low manganese as well. Hence it is ideal for the repair of galvanizing bath tanks. The rate of dissolution of iron (i.e. corrosion) from the tank into the molten zinc is low if the silicon and carbon content of steel is low. Hence the repair made by Diffusaloy GZB-LH, which has a weld metal composition having carbon and silicon less than 0.05% have excellent to corrosion by molten zinc and thus they last for a longer duration. Diffusaloy GZB-LH is a low hydrogen version of Diffusaloy-GZB.

Applications:

The most important application of this electrode is in the welding of tanks of galvanizing baths and for filling up the worn out portions of the galvanizing bath tanks.

Procedure:

Machine /grind to remove fatigued metal.

Hold electrode at right angle in the direction of travel.

Do not weave during contact welding.

Avoid arc gap where distortion and positional welding are important.

<u>Technical Data</u>	:	DIFFUSALLOY GZB LH		
Size (mm)	:	3.15	4.0	5.0
Recommended Welding Current (Amps)	:	110 – 130	140 – 180	200 - 240
Tensile Strength	:	43 kgf / mm ²		
Elongation	:	30%		

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