

UNILOY 685

A unique low heat input electrode with superior alloy formulation for high strength joining and cushioning of medium and high carbon steels, tool and die steels, stainless steels, and stainless to carbon steels. Also recommended for overlays on carbon steels for corrosion resistance and high temperature service upto 1100°C.

Applications:

Parting tools, joining hadfied steel parts in earth-moving machinery, track pads furnace parts, cooler plates, sugar mill roller journals etc.

Procedure:

- 1) Gouge out/grind, worn, damaged and fatigued metal/cracks.
- 2) Use the electrode on AC/DC+ power source.
- 3) Employ short stringer beads.
- 4) Use skip and staggered welding sequence.

<u>Technical Data</u>	:	UNILOY 685			
Size (mm), Ø	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	45 - 90	60 – 110	100 –140	140 - 190
Tensile Strength	:	68 kgf/ mm ² (min.)			
Elongation	:	30 %			
Hardness	:	160-190 BHN			
Tip Colour	:	Deep Orange			

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