



- A- Mechanical Strength
- B- Crack Resistance
- C- Versatility
- D- Low Heat Input

## SUPER STANALLOY DS 34 AC/DC+

### TYPICAL APPLICATIONS :

Suited for Dies, tools, springs, cushion layer, Joining dissimilar & unknown steel & stainless steel combinations. Machinable build-up and overlay. Commercial & Earth moving Chassis frames, gears, springs, tool steels, cushion layer prior to hard facing protection, dissimilar alloy steels joining.

### OUTSTANDING FEATURES :

- ★ Frostarc Formulation leading to low amperage welding with superior penetrations at low amperages.
- ★ Superior " ferrite balance " chemistry engineered to give superior crack free weld deposits on high alloys and high carbon steels with HAZ cracking.
- ★ Contact type & Self lifting slag electrode design.
- ★ Resistance to surface contaminants & excellent impact resistance.
- ★ Tough, high crack resistance combined with smooth arc transfer.
- ★ All position welding capability.

### RECOMMENDATIONS :

Frostarc coating plus high-alloy core generates highly ionized arc for "spray-type" transfer of weld metal. Outstanding strength and weldability. CDS produces mini & dense grain structure for high strength, high toughness and ductility. For combinations of similar and dissimilar steels and joining steels of different thicknesses. High versatility of the electrode, makes it universal alloy for welding all dissimilar and unknown combinations of base metals.

### PROCEDURE :

Clean weld area and follow usual joint preparation. Bevel heavy Sections 60°-90°. For high alloy steels, a preheat up 200°C is recommended. Hold a short arc. Run stringer beads. Intermittent welding may be used – specially on high alloy steels. Peening will relieve internal stresses. Self lifting slag help in getting sound defect free welding. Interpass temperature has to be below 300°C.

### RECOMMENDED AMPERAGES :

SIZE(mm)	RANGE	SIZE(mm)	RANGE
4.00	100-140	2.5	50-70
3.15	80-110	1.6	35-50

### TENSILE STRENGTH :

1,35,000 PSI (910 N/ mm<sup>2</sup>)