

# PROLINE

professional welding supplies



## DURALLOY® 214

### DESCRIPTION

Duralloy® 214 is a high chromium carbide hardfacing electrode for high abrasion and mild impact applications. Deposits take on a high polish, producing excellent frictional and sliding abrasion resistance. Use on carbon and alloy steels, stainless steels and cast iron.

Heat and Corrosion Resistant - Corrosion resistance is equal to straight chromium steels and it retains it's hardness up to 1000°F(538°C).

Duralloy® 214 offers good out-of-position welding characteristics on either AC or DC. Fast deposition rate and easy slag removal. It produces minimum dilution for high first pass hardness and deposits are extremely smooth - almost ripple free.

### SPECIFICATIONS

Hardness ..... 58-62 Rc  
Deposit Thickness ..... 2-3 Passes  
Relief checks readily to prevent stress build-up.  
Cannot be flame cut.

### APPLICATION

- Farm implements
- Asphalt and concrete mixer paddles
- Road ripper teeth
- Ditch digger teeth
- Conveyor screws
- Dredge pump impellers
- Dust fan blades
- Crushing and pulverizing tools
- Grader blades
- Muller tires
- Feed screws

### WELDING PROCEDURES (POLARITY - AC/DC STRAIGHT OR REVERSE)

Due to lower dilution, DC straight polarity will produce a higher first pass hardness and is also ideal for thin sections. Remove all damaged or fatigued metal. Preheating is generally not required. However, for high carbon or alloy steels and cast iron, a preheat of approximately 400°F (204°C) is recommended. Maintain a short to medium arc using a weave technique. Remove slag.

SIZE	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
Amperage	65 - 95	110 - 140	160 - 200	210 - 270

### PACKAGING

SIZE	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
10 Lb Pack (4.54 Kg)	Standard	Standard	Standard	Available