

PROLINE

professional welding supplies

DURALLOY®

QUALITY
MANUFACTURED
IN THE USA

DURALLOY® 21

DESCRIPTION

Duralloy® 21 is a "self-hardening" wear resistant overlay engineered for abrasion and abrasion combined with medium impact. The alloy chemistry provides good resistance to spalling and chipping while the special low hydrogen coating minimises dilution and helps to eliminate underbead cracking.

Use on carbon and low alloy steels, It can be used out-of-position and can be used with all types of AC or DC equipment.

SPECIFICATIONS

Hardness as Deposited56-58 Rc
Deposit Thickness2-3 Passes
Deposits are non-machinable

APPLICATION

- Excavator parts
- Tamping tools
- Screw conveyors
- Elevator bucket lips
- Muller tires
- Mining
- Earthmoving and construction equipment
- Bucket lips and teeth
- Dozer and grader blades
- Grader end bits
- Post hole augers
- Wear areas on clamshell
- Dragline and shovel buckets

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

Due to lower dilution, DC reverse 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	1/8" (3.2mm)	5/32" (4.0mm)	3/16" (4.8mm)
Amperage	110 - 130	130 - 160	150 - 250

PACKAGING

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

Ph: 0800 699 353
sales@prolinewelding.com