

# PROLINE

professional welding supplies

# DURALLOY®

QUALITY  
MANUFACTURED  
IN THE USA

## DURALLOY® RSP

### DESCRIPTION

Duralloy® RSP deposits an Austenitic-ferritic microstructure which is highly crack resistant. Very commonly used for joining and overlaying problem steels of unknown chemistry.

Other applications include hardenable and armour steels to themselves or each other without pre-heat. Can be used to weld repair or reclaim 13% Mn (Hadfield) steel used in rock crushing plant or earth moving equipment.

An excellent electrode for surfacing of components subject to compressive loads such as alloy rails, crossing parts frogs etc.

### SPECIFICATIONS

Tensile Strength.....830 MPa  
Yield Strength.....500 MPa  
Elongation.....41%  
Hardness as Welded.....10 HRC  
Work Hardness.....50 HRc

### APPLICATION

- Manganese components
- Railroad components, crossings, frogs etc.
- Problem steels
- Buffer layers prior to hardsurfacing

### WELDING PROCEDURES (POLARITY – AC/DC STRAIGHT)

Do not pre-heat. Use the lowest possible amperage and move the electrode as quickly as feasible. Allow to cool slowly. Suitable for flat, horizontal, vertical up.

SIZE	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
Amperage	60 - 85	90 - 150	165 - 270

### PACKAGING

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

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