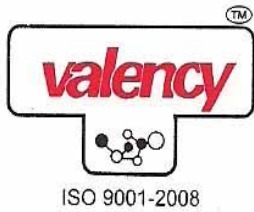


Low Heat Input Electrodes for maintenance and Repair

'Valency' manufactures a wide range of low heat input Electrodes which are widely recognized for superb welding characteristics viz. very low spatter, smooth arcing and excellent slag detachability in addition to providing prolonged service life of components subjected to different types of wear factors.



PRODUCT CATALOGUE FOR Steel & Dissimilar Alloys



LOW HEAT INPUT CONSUMABLES FOR MAINTENANCE & REPAIR

A. ELECTRODES FOR STEEL & DISSIMILAR ALLOYS

Product	Description	Applications	Typical Properties	Size and Current					
VALMATIC [AC/DC+]	ALL POSITION, CONTACT WELDING, EASY DETACHABILITY, EXCELLENT BEAD FINISH,	Air Conditioning parts, Machine guards, Doors & Windows	U.T.S. 450-500 N/mm ² , Elongation 22%	Size (mm)	2.50	3.15	4.0	5.0	
				Amps	50-90	90-130	140-170	170-220	
VALMET 516 LH [AC/DC+]	ALL POSITION, LOW HYDROGEN, HIGH STRENGTH & RECOVERY, RADIOGRAPHIC.	Low & Medium Carbon Steels, Heavy Sections, Restrained joints under dynamic load, such as crane jigs & booms Chassis etc.	U.T.S. 550-600 N/mm ² , Elongation 26%	Size (mm)	2.50	3.15	4.0	5.0	
				Amps	70-100	100-140	130-175	165-220	
VALMET 506 MLH [AC/DC+]	ALL POSITION, LOW HYDROGEN, HIGH STRENGTH, GIVING HIGH IMPACT RESISTANCE & DUCTILITY UPTO 525° C	Applications: for joining & build up of carbon- moly steels, medium high tensile & low alloy steels, boilers, pressure vessels, pipes & tubes of such composition.	U.T.S. 570-620 N/mm ² , Elongation 22%	Size (mm)	2.50	3.15	4.0	5.0	
				Amps	70-100	100-140	130-175	165-220	
CRONIMO 536 [AC/DC+]	BASIC, MEDIUM HEAVY COATED, LOW HYDROGEN, DEPOSITING WELD METAL OF 1%Cr/2.5% Ni/ 0.70%Mo TYPE	Welding of HT steel machinery parts, earth moving, automobile, chemical plant parts and armor plates using Ni-Cr-Mo steels, Repairing steam turbine rotors etc	U.T.S. 720-750 N/mm ² , Elongation 22%, CVN at -60oC 5.0KgM	Size (mm)	2.50	3.15	4.0	5.0	
				Amps	70-100	100-140	130-175	165-220	
VALMET 526 [AC/DC+]	WORK HARDENING ALLOY FOR JOINING & REPAIRING CRACKS IN MANGANESE STEELS (12%) AND JOINING MN STEELS TO OTHER STEELS	Shovels, Buckets, Sprockets, Track Pads, Crushers etc.	U.T.S. 650 N/mm ² , Elongation 30-40%, min Hardness : As Deposited 160 BHN Work hardened 440 BHN	Size (mm)	2.50	3.15	4.0	5.0	
				Amps	40-70	60-120	100-160	140-190	

Product	Description	Applications	Typical Properties	Size and Current				
VALMET 5260 [AC/DC+]	WORK HARDENING ALLOY FOR JOINING & REPAIRING CRACKS IN MANGANESE STEELS (12%) AND JOINING MN STEELS TO OTHER STEELS	Shovels, Buckets, Sprockets, Track Pads, Crushers etc.	U.T.S. 650 N/mm ² , Elongation 30-40%, min. Hardness : As Deposited 160 BHN Work hardened 440 BHN	ize (mm) Amps	2.50 40- 70	3.15 60- 120	4.0 100- 160	5.0 140- 190
CAMN 56 [AC/DC+]	HIGH MANGANESE STEELS, MANGANESE STEEL TO MILD STEEL, CARBON & LOW ALLOY & STAINLESS STEELS, CUSHION LAYER ON FATIGUED MANGANESE & OTHER STEELS PRIOR TO HARDFACING.	Shovels, Buckets, Sprockets, Track Pads, Crushers etc.	U.T.S. 650 N/mm ² , Elongation 30-40% min. Hardness: As Deposited 160 BHN Work hardened 440 BHN	Size (mm) Amps	2.50 40- 70	3.15 60- 120	4.0 100- 160	5.0 140- 190
MNX 221 [AC/DC+]	JOINING & REPAIR OF HIGH MANGANESE STEELS, MANGANESE STEEL TO MILD STEEL, CARBON STEEL & SS, CUSHION LAYER ON FATIGUED MANGANESE & OTHER STEELS	Shovels, Excavator Buckets, Sprockets, Track Pads, Jaw crushers, pinions	U.T.S. 680-700 N/mm ² , Elongation 30-35%	Size (mm) Amps	3.15	4.0 75- 130	5.0 100- 160	140- 190
VALMET 576 [AC/DC+]	FOR JOINING STAINLESS STEEL TO MILD STEEL & CARBON STEEL, OVERLAYS & CUSHION LAYER	Shafts, Valve seats & faces, roller journals, bucket cracks, hammers, jaw crushers.	U.T.S. 680 N/mm ² , Elongation 30%, Hardness 160-180 BHN	Size (mm) Amps	2.50 40- 70	3.15 60- 120	4.0 100- 150	5.0 140- 190
VALMET 586 OCM [AC/DC+]	FOR JOINING & REPAIR OF LOW, MEDIUM, HIGH ALLOY STEEL OR STEEL OF UNKNOWN COMPOSITION, SUPERIOR CRACK RESISTANCE, WELDABILITY & MACHINABILITY	Gears, tool steels, dies, shafts, cushion layer	U.T.S. 800-850 N/mm ² , Elongation 20-22% min.	Size (mm) Amps	2.50 40- 70	3.15 75- 130	4.0 100- 165	5.0 130- 180

Product	Description	Applications	Typical Properties	Size and Current				
VALMET 586 [AC/DC+]	SUPERIOR ELECTRODE FOR UNKNOWN, DISSIMILAR, DIFFICULT TO WELD STEELS.	Gears, tool steels, dies, shafts, cushion layer.	U.T.S. 820-860 N/mm ² , Elongation 24% (Typical)	Size (mm)	2.50	3.15	4.0	5.0
				Amps	40-70	75-130	100-165	130-180
VALMET 586 FG [AC/DC+]	DEPOSITS CONTROLLED & FINE GRAINED DUPLEX AUSTENO FERRITIC WELD, HIGH STRENGTH, TOUGHNESS, DUCTILITY AND CRACK RESISTIVITY. OUTSTANDING WELD CHARACTERISTICS	joining, surfacing, & repair of high alloy, high strength, difficult to weld, unknown & dissimilar steels components & also manganese steels.	U.T.S. 820-860 N/mm ² , Elongation 24% (Typical)	Size (mm)		2.50	4.0	5.0
				Amps		40-70	100-165	130-180
VALMET 588 [AC/DC+]	PRECISELY BALANCED FINE GRAINED DEPOSIT GIVING DUPLEX STRUCTURE OF AUSTENITE & FERRITE WITH SUPERB WELDABILITY	Gear Box , Gear Teeth, Shafts, Tools & Dies, Joining Wear plates, Leaf Spring, Cushion Layer	U.T.S. 860 N/mm ² , Elongation 24%	Size (mm)	2.50	3.15	4.0	5.0
				Amps	40-70	75-130	100-165	130-180
VALMET FVW 01 [AC/DC+]	Cr/Ni/Mo ALLOYED HIGH STRENGTH, HIGH CRACK RESISTANT SS ALLOY	joining and surfacing of armour plates, tough low alloy steels, as buffer layer prior to roll surfacing etc.	U.T.S. 735 N/mm ² , Elongation.36%	Size (mm)	2.50	3.15	4.0	5.0
				Amps	40-70	75-130	100-165	130-180