



Digestor Reducer

## A high alloy electrode for joining and over laying on nickel based metals.

### Typical Applications:

Hot forging/ cutting tools, die stamps, vats, resorts, pipe lines, pumps, pickling/plating tanks.

### Outstanding Features:

- Machinable deposits having unusual hot toughness.
- Resists deformation from static or cyclic loads at high temperatures.
- Resistance to oxidising acids.

### Recommendation:

For overlaying hot metal handling equipment. Unsurpassed resistance to oxidising acids, mixed acids, salts and chlorine-bearing compounds at normal to elevated temperatures. Recommended for overlaying or joining dissimilar high alloys, particularly of the nickel-based types such as the hastelloys and inconel or for joining these alloys to mild, low alloy or stainless steels.

### Procedure:

Remove fatigued metal. Use of EWAC GOUGETRO is recommended. Apply EWACTRO HF 79 using either ac or dc reverse polarity. Preheat is usually not necessary unless very heavy sections are involved. When surfacing and cladding both stringer bead and weaving techniques may be employed. When fabricating high alloys, stringer beading is preferred. Hold a close arc and back whip craters. Remove slag.

### Recommended Amperages:

Size (mm)	I - Range	II - Range
2.5	75 - 90	50 - 65
3.15	105 - 130	70 - 95
4.00	130 - 160	90 - 120
5.00	165 - 200	125 - 165

**Tensile Strength:** 75 Kg/mm<sup>2</sup>  
(1,05,000 psi)