



Pelton Bucket

Suitable alloy for joining application and protective coating on 13% chromium steel.

Typical Applications:

Hydraulic turbine, pump housings, die casting moulds, valves, shafts, rolls, pelton bucket.

Outstanding Features:

- Good corrosion resistance.
- Excellent notch toughness.
- Easily machinable deposit.
- Ideal for cavitation & erosive wear.

Recommendation:

An application-designed hardfacing alloy electrode for protective coatings, repair and joining applications on 13% chromium steel. The weld deposits are very tough and show consistent and homogeneous properties. The electrode is easy to use in all positions.

Procedure:

Clean weld area. Tack thin parts every 30 to 50 mm. On 13% chrome steels, preheat to 150°C. Deposit with a short to medium arc keeping the electrode almost vertical. Whip back craters and chip slag between passes. Do not peen. For developing best mechanical properties, carry out stress-relieving at 580°C for four hours and slow cool the component. Follow instructions of the steel manufacturer for heat treatable base metal. Machine deposits with carbide tipped tools.

Recommended Amperages:

Size (mm)	I - Range	II - Range
3.15	100 - 120	100 - 110
4.00	130 - 140	120 - 130

Tensile Strength: 107 Kg/mm²
(1,50,000 psi)

Hardness: 33 - 40 HRC (3 layer)