



TOTAL MAINTENANCE WELDING REPAIR SOLUTIONS

# Premium Strength, Work Hardening, Non Cracking, Slag Free Electrode for All Dissimilar steels.

#### Features :

- DELTATEC DT3300 is All position AC/DC coated electrode, depositing high alloy weld metal.
- Designed to produce crack-free deposits having very high Mechanical properties.
- Superior performance on limited input AC Machines.
- Ideal for repairing Dies, Tools, Spring Steel and any Dissimilar Steel combinations.
- Unknown steels and Steels in Hardened condition eliminating Guess work.
- Superior Work Hardening Properties.

#### **Advantages :**

- Welding Dissimilar Steels of any Composition
- Excellent Heat (Upto 1000° C) and Corrosion Resistance.
- High Resistance to Under bead Cracking, Hot Cracking and Stress Corrosion Cracking.
- Obtains Fine Grain Structure.
- Obtains High Tensile Values and Ductility with out Heat Treatment.
- Ferrite Balanced Alloy Chemistry.
- Special Flux Formulation eliminates Slag interference in Horizontal Fillets.

### **Applications :**

- Due to Higher Strength and Crack resistance, It is ideal for Repairing of Dies, Tools, Spring Steel, Manganese Steels, Difficult to weld Steels and any other Dissimilar steel Combinations.
- Repairing Worn parts of Damaged Gear teeths, Shafts Keyways and any Moving Parts. .
- Suitable for welding of High Temperature and Corrosion resistance Alloys.
- Suitable for welding Difficult to weld Steels such as Manganese Steel and Armour Plate.
- Can be Used as a Underlay or buffer layer prior to Hard Facing.

TYPICAL ALL WELD METAL PROPERTIES					
Tensile Strength as Welded	128,000 Psi(880 Mpa)	Hardness 320 BHN			
Tensile Strength as Work Hardened	186,000 Psi(1280 Mpa)	Elongation 32 %			

OPERATIONAL AND PACKAGING DATA							
ELECTRODE	ELECTRODE	WELDING CURRENT	PACKA		AGING		
SIZE (mm)	LENGTH (mm)	RANGE (amps)	Kg/PKT		Pieces/Kg		
2.60	300	50 - 75	2.5	5	58		
3.20	350	75 - 110	2.5	5	31		
4.00	350	110 - 150	2.5	5	20		

## **International Specifications**

- AWS/ASME A 5.4 E 312-17
- DIN 8556 E29.9 R 23
- ISO 3581:E 29.9 R 32
- BS 2926 1984 29.9R

### WELDING TECHNIQUES :

- Clean welding surface. Adjust amperage within recommended range and deposit material maintaining short to medium arc length.
- Tilt electrode 15° in the direction of travel.
- For rapid Filleting raise amperage slightly and drag weld inclining the electrode 45° in the direction of travel.
- Back-whip craters and remove slag between passes.
- Use any constant current AC transformer or DC generator-rectifier providing minimum 55 volts open circuit.

Recomented for DC + or AC (minimum 45 OCV) operations.