

# Durelloy™

## HEAT TREATED HOT ROLL ALLOY

Durelloy HR (hot roll) and Durelloy-TGP™ heat treated alloy steel can be welded using standard welding methods.



### Durelloy Welding Instructions

- **Pre-heating**  
Because of the carbon and other alloy elements, pre-heating to approximately 800° F is recommended. Keep at pre-heated temperature during welding to prevent under-bed cracking.
- **Equipment**  
No special electrode needed. Standard low-hydrogen rods recommended for maximum strengths. Most popular AWS designations are E7016, 7018, 10016 & 10018 (preferred).
- **Surface & Voltage**  
Welding rods should be clean and dry. Insure welding surface is clean. Hold inter-pass temperature at 800° F. Use minimum recommended arc voltage and amperage and reduce amperage slightly for secondary and finishing passes.
- **Method**  
Use the smallest-diameter electrode, rod or wire that will do the job. Travel slowly and straight. Use several small stringer beads rather than deposits. A weave bead of 2½ times the rod diameter can be used. Brush slag and dirt from the beads frequently.
- **Cracks**  
When welding cracks, cracks should be U-ed not V-ed; sharp angles tend to induce cracking. Take care to grind away any and all existing cracks.
- **Post-heating**  
To relieve welding stresses, a post-heat of approximately 400° F should be maintained for 2 hours.