



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

No special electrode needed. Standard low-hydrogen rods recommended for maximum strengths. Most popular AWS designations are E7016, 7018, 10016 and (10018–preferred).

- Because of the carbon and other alloy elements, pre-heating to approximately (800 degrees) is recommended. Keep at pre-heated temperature during welding to prevent under-bed cracking.
- Welding rods should be clean and dry. Insure welding surface is clean. Hold inter-pass temperature at (800 degrees). Use minimum recommended arc voltage and amperage and reduce amperage slightly for secondary and finishing passes.
- 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.
- 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.
- To relieve welding stresses, a post-heat of approximately (400 degrees) should be maintained for (2) hours.