

Comparison of Depo Tech with other overlay techniques

⊙ : Best ○ : Better △ : Acceptable X : Not Acceptable

Item	Process	Spot Welding		Argon Gas Shielding Welding	Laser Welding
		Sheet, Wire	Paste, Powder		
01. Heat Input	Low	Low	Low	High	High
02. Distortion, Under Cut	⊙	⊙	⊙	X	△
03. Bond Strength	○	X	X	⊙	⊙
04. Thickness of Overlay	< 3m	< 0.4mm	< 0.5mm	> 1mm	> 0.3mm
05. Thickness Control	○	○	○	X	△
06. Edge Overlay	⊙	△	X	○	⊙
07. Pinhole Filling	⊙	X	○	○	○
08. Possible Size of Mold & Die	Small to Large	Small to Large	Small to Large	Medium & Large	Small
09. Size of Machine	Small	Medium	Medium	Medium	Large
10. On-site Repair	⊙	△	△	X	X
11. Position of Overlay	All Position	Down	Down	Down	Down
12. Pre & Post Heating	No Required	No Required	No Required	Required	No Required
13. Deposition Speed	○	X	X	⊙	○
14. Applicable Substrates	Steel, Al, CuAlloy	Steel	Steel	Steel, Al	Steel, Al
15. Consumable	Electrode *1	Sheet, Wire	Paste, Powder	Welding Rod	Welding Rod
16. Gas Shield *2	Argon Gas	None	None	Argon Gas	Argon Gas
17. Hand Finishing	⊙	○	○	X	△
18. Hard Coating	Possible	Not Possible	Not Possible	Not Possible	Not Possible
19. Cost of Machine	Cheap	Cheap	Cheap	Very Cheap	Very Expensive
20. Safety for Operator	Safety	Safety	Safety	Ultraviolet Ray	Not Safety

*1 : A consumable rotation electrode is transferred to molds and dies.

*2 : Argon shielding gas prevents oxidation and increases bonding strength.