

DIFFUSALLOY 800 ELH

A newly formulated basic-coated “Extra Low Hydrogen” “Lo Temp” alloy designed for X-ray quality welds on mild steels, medium carbon and low alloy high strength steels. Deposits exhibit very high strength and provide unique resistance to hydrogen-induced embrittlement.

Applications:

Diffusaloy 800 ELH is recommended for x-ray quality welds on a variety of medium carbon and low alloy high tensile steels, providing unique hydrogen free deposits with superior impact resistance at normal and sub-zero temperatures. Recommended applications include high pressure piping, overhead cranes, hoists, steel casting defects, steel gears, sprockets, loco frames, hubs, pumps etc.

Procedure:

Clean weld area to remove surface contamination and gouge/grind all cracks; Use electrode on AC/DC + at the lowest amps; Maintain a short arc (can be used for ‘contact welding’ also); Deposit stringer or modified weave technique. Allow to cool and slag is removed easily. Preheat is usually not necessary unless very heavy sections are involved.

<u>Technical Data</u>	:	DIFFUSALLOY 800 ELH		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	100 - 140	130 – 170	160 - 200
Tensile Strength	:	55-60 kgf/ mm ²		
Yield Strength	:	44-48 kgf/ mm ²		
Elongation (l = 5d)	:	30% Min.		
CVN Impact Strength at – 20 ⁰ C	:	8-10 kgfm/cm ²		

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