DIFFUSALOY 916 L


**Applications:**

For production and maintenance applications in chemical and paper industries, where service conditions demand excellent resistance to pitting and corrosion under strongly oxidizing media. Diffusaloy 916 L being ELC type, minimizes carbide precipitation and thus eliminates intergranular corrosion.

**Procedure:**

Clean weld area and clamp long seams. Use backup plates to minimize distortion on thin sheets. Track-weld at short intervals. Use electrode on AC/DC+ at lowest possible amps. Maintain very short arc and chip slag between passes. Avoid weaving.

**Technical Data**

<table>
<thead>
<tr>
<th>Parameter</th>
<th>DIFFUSALOY 916L</th>
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<tbody>
<tr>
<td>Tensile Strength</td>
<td>55 kgf / mm² (Min.)</td>
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<tr>
<td>Elongation</td>
<td>30% (Min.)</td>
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<tr>
<td>CVN Impact Strength at 20°C</td>
<td>8 – 12 kgfm / cm²</td>
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<tr>
<td>Coating Color</td>
<td>White</td>
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<tr>
<td>Tip Colour</td>
<td>Dark Brown</td>
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<tr>
<td>Size (mm)</td>
<td>2.5, 3.15, 4.00, 5.00</td>
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<tr>
<td>Recommended Welding Current (Amps)</td>
<td>40 – 70, 60-100, 75-130, 125-160</td>
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