

CORDIFF 308L

Characteristics:

CORDIFF 308L is specially developed C-Cr-Ni stainless steel flux cored wire with high alloying content, which produces bright and smooth bead. C-Cr-Ni chemistry is so controlled; the microstructure is mostly austenitic with some amount of ferrite. Due to the presence of Ferrite, the weld metal has lower susceptibility to cracking. Weld metal have superior mechanical properties and with higher toughness in cryogenic condition also. Better intergranular corrosion resistance as carbon content is low.

CORDIFF 308L have stable and smooth arc, with very good slag detachability.

Application:

For welding and joining of austenitic stainless steel 304, 304L, 308L and 18-8 type steels and alloy steels. Also recommended for tough and wear resistant overlays on all steels.

Major alloying elements:

C	Si	Mn	Cr	Mo	Ni
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Mechanical properties of weld metals:

Tensile strength (kgf/mm²)	Elongation (%)
57 min.	35 min.

Welding Parameters:

POLARITY: DC + ve

SHIELDING GAS: 80%Ar/Balance CO₂ or 100% CO₂

DIA. (mm)	VOLTAGE	AMPS
1.2	21 – 25	120 - 200
1.6	24 – 27	180 – 230
2.0	25 – 28	220 – 250
2.4	26 – 28	260 – 300
2.8	27 – 30	300 - 340

Standard Packing:

Spool = 15 kgs (± 1kg) Spool = 25 kgs(± 1kg)

DIFFUSION ENGINEERS LIMITED

Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085

Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036

Works III : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984

Email : info@diffusionengineers.com Website : www.diffusionengineers.com

Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.