

DIFFUSALLOY 309L

Description:

A unique low heat input electrode with superior alloy formulation for high strength joining and cushioning of medium and high carbon steels, tool and die steels. Stainless steels and stainless to carbon steels. Also recommended for overlays on carbon steels of corrosion resistance and high temperature service upto 1100⁰C.

Applications:

Parting tools, joining Hadfield steel parts in earth-moving machinery, track pads, furnace parts, cooler plates, sugar mill roller journals etc.

Procedure:

- i. Pre-heat at 150⁰C for one hour is recommended before use.
- ii. Clean weld area. Clamp and tack weld at short intervals.
- iii. Use electrode on AC/DC + at the lowest amps.
- iv. Maintain very short arc and chip slag between passes. Avoid weaving.

<u>Technical data</u>	:	DIFFUSALLOY 309L			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	50 – 80	80 – 110	100 – 140	140 - 190
Tensile Strength	:	53 kgf / mm ² (Min.)			
Elongation	:	30% (Min.)			
Tip Colour	:	Deep Orange			

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