

DIFFUSALLOY 1018

A specially designed hydrogen controlled all positional electrodes with alloying elements like Nickel, Chromium and Molybdenum to give a very high strength of 1,00,000 p.s.i. and can be used for welding of Ni-Cr-Mo cast and wrought alloys. The electrodes is designed to produce fine rippled beads of radiographic quality.

Applications:

High tensile machinery parts, parts of earth moving equipment, auto parts, armour steel, chemical plants, steam turbine retorts in service temperature upto 500⁰ C, case hardened steels etc. Salvaging of alloy Steel casting og similar composition.

Procedure:

Clean weld area and gouge/grind all cracks. set lowest current and maintain a short arc (can be used for 'contact welding'). deposit stringer or modified weave technique. allow to cool and slag is removed easily. preheat is usually not necessary unless very heavy section are involved.

| | | | | |
|--|---|-----------------------------|-----------|-----------|
| <u>Technical Data</u> | : | DIFFUSALLOY 1018 | | |
| Tensile Strength | : | 73-76 kgf / mm ² | | |
| Yield Strength | : | 69-72 kgf/mm ² | | |
| Elongation (l=4d) | : | 16-20 % | | |
| CVN Impact strength at 50 ⁰ C | : | 4-8 kgfm/cm ² | | |
| Coating color | : | Red | | |
| Tip Color | : | Grey | | |
| Size (mm) | : | 3.15 | 4.00 | 5.00 |
| Recommended Welding Current (Amps) | : | 90-140 | 140 – 180 | 190 – 250 |

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.