

DIFFUSALLOY 905

A special low heat input electrode developed with superior alloy formation which offers controlled Ferrite-Austenite structure for high strength joining and cushioning of medium and high carbon steels, tool and die steels. Joining of stainless steels and stainless steel to carbon steels. Also suitable for overlays on carbon steels. Excellent corrosion resistance and high temperature service upto 1100⁰C.

Applications:

Special Application includes Anchor joining, Stainless steel to mild steel, Inlet feed Pipe of Sponge Iron Plant. Parting tools, joining Hadfield steel parts in earthmoving machinery, track pads, furnace parts, cooler plates, sugar mill roller journals etc.

Procedure:

Gouge out / grind all damaged, worn fatigued metal/cracks. Clean weld area and clamp long seams. Use back up plates to minimize distortion on thin sheets. Tack at short intervals. Use electrode on AC/DC + at lowest amps. Maintain very short arc and chip slag between passes. Avoid weaving. Employ short skip welding sequence with staggered and stringer weld beads.

<u>Technical Data</u>	:	DIFFUSALLOY 905			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	50 – 75	80 – 110	100 – 140	140 - 180
Tensile Strength	:	55 kgf / mm ² (Min.)			
Elongation	:	30% (Min.)			
Tip Colour	:	Deep Orange			

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