

DIFFUSALLOY 917 L

An Extra Low Carbon “Lo Temp” austenitic stainless steel electrode for all-positional welding of AISI 316,316 L, 317 and 318 stainless steels.can also be used for joining and overlaying on a variety of dissimilar steels,especially where the weld deposits are subject to thermal shocks.

Applications:

For production and maintenance applications, on stainless steel, CrNiMo steels or lower alloy steels. Also suitable for joining these steels to mild steels or alloyed corrosion steels. Working temperature from -60° C to $+400^{\circ}$ C. The corrosion resistance against non oxidizing media and media containing chloride ions is very good. Weld metal resistance to hot cracking and microfissuring.Can also be used for Clad steels especially with 12-14% straight chrome types.

Procedure:

Re-dry electrodes at $150-200^{\circ}$ C for one hour. 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 between passes. Avoid weaving.

<u>Technical Data</u>	:	DIFFUSALLOY 916L			
Tensile Strength	:	56 kgf / mm ² (Min.)			
Elongation	:	35% (Min.)			
Coating Color	:	White			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 – 70	70-100	90-150	135-185

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.