

DIFFUSALLOY 8018 W2

DESCRIPTION:

DIFFUSALLOY 8018 W2 is a unique product designed especially for welding the low-alloy, high-strength “weathering” grade steels such as ASTM A588 and A242. The uniform colour match of weld deposit with “weathered” steels makes this product an excellent choice for welding these grades.

A specially formulated coated “Extra Low Hydrogen” “Lo Temp” alloy designed for X-ray quality welds on mild steels, medium carbon and low alloy high strength steels. Deposits exhibit very high strength and provide unique resistance to hydrogen-induced embrittlement.

APPLICATIONS:

DIFFUSALLOY 8018 W2 developed for the welding of weather resistant steels with same steel And with other grades of steels having same or lower strength to IS: 2062. It can also be used in different industries such as Rail Road Car, Shipbuilding, Automotive, General Fabrication, Bridge Construction, Civil Construction etc. It is recommended for joining or building up carbon steels and alloy steels, without porosity or cracking (especially of the hydrogen induced type), with exceptionally high physical properties. An all-position electrode with high impact strength.

PROCEDURE:

Before use redrying of electrodes for 2 hrs at 350⁰C. Clean weld area to remove surface contamination and gouge/grind all cracks. Use electrode on AC/DC + at the lowest amps. Maintain a short arc (can be used for ‘contact welding’ also). Allow to cool and slag is removed easily. Preheating and post weld heat treatment of base materials to be carried out according to the steel manufacturer’s instruction.

TECHNICAL DATA	:	DIFFUSALLOY 8018 W2			
Size (mm)	:	2.5	3.15	4.0	5.0
Recommended Welding Current (Amps)	:	60 - 90	90 – 120	120 – 150	150 - 200
Tensile Strength	:	50 kgf / mm ² (min.)			
Elongation (l = 5d)	:	22% (min.)			
CVN Impact value at -20 ⁰ C	:	50 J (min.)			
Tip Colour	:	White			

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