

## DIFFUSALLOY 304 L

An advanced Extra Low Carbon 'Lo-Temp' austenitic stainless steel electrode designed for all positional welding of AISI 301, 302, 304, 304L, 308L stainless steels. Alloy exhibits exceptional weldability with spatter – free deposits.

### Applications:

For production and maintenance welding of AISI 301, 302, 304, 304 L, 308L stainless steels. Excellent for applications in dairy, food, chemical industries and nuclear plants. Extra low carbon and low amp application help considerably in minimizing carbide precipitation.

### Procedure:

Preheat electrode to 150<sup>0</sup>C to reduce moisture.  
 Clean weld area and provide clamps / backup plates to minimize distortion on thin plates. Tack-weld at short intervals.  
 Use electrode on AC / DC+ at lowest possible amps.  
 Maintain very short arc and chip slag between passes. Avoid weaving.

<u>Technical Data</u>	:	<b>DIFFUSALLOY 304 L</b>			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 – 70	65 – 100	75 – 130	125 - 160
Tensile Strength	:	53 kgf / mm <sup>2</sup> ( Min.)			
Elongation	:	35% (Min.)			
CVN Impact Strength at -20 <sup>0</sup> C	:	65J (Min.)			
Tip Colour	:	Light Green			

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