

DIFFUSALLOY 316 L

A “Lo Temp” Extra Low Carbon all – positional austenitic stainless steel electrode for the welding of stainless steels of AISI types 316, 316L, 317 and 318. Deposits of Diffusaloy 316L offer superior resistance to intergranular corrosion.

Applications:

For production and maintenance applications in chemical and paper industries, where service conditions demand excellent resistance to pitting and corrosion under strongly oxidizing media.

Procedure:

Preheat at 200⁰C for one hour before use. 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 possible amps.

Maintain very short arc and chip slag between passes. Avoid weaving.

<u>Technical Data</u>	:	DIFFUSALLOY 316L			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 – 70	80 – 115	100 – 140	130 - 175
Tensile Strength	:	55 kgf / mm ² (Min.)			
Elongation	:	30% (Min.)			
CVN Impact Strength at 20 ⁰ C	:	9 – 12 kgfm / cm ²			
Tip Colour	:	Grey			

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