

DIFFUSALOY 818

A newly formulated basic-coated "Low Hydrogen Electrode" "Lo Temp" alloy designed to weld low alloyed Cr-Mo steels, low alloy tempered steels and similar alloyed case hardened steels. Deposit exhibit very high strength and provide unique resistance to hydrogen induced embrittlement.

Applications:

Diffusaloy 818 is an all positional recommended for joining or build up on Cr-Mo steels in the manufacture of vessels and pipe lines at working temperature up to 550°C. Also suitable for low alloy tempered steels and similar alloyed case hardening steels. Welding properties are excellent and easy slag detachability.

Procedure :

Clean weld area to remove surface contamination and gouge/grind all cracks. Maintain a short arc (can be used for 'contact welding' also); Preheat is usually not necessary unless very heavy sections are involved.

<u>Technical Data</u>	:	DIFFUSALOY 818		
Size (mm)	:	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	100 - 140	130 - 170	160 - 200
Tensile Strength	:	56-62 kgf/ mm ²		
Yield Strength	:	48-50 kgf/ mm ²		
Elongation (l = 5d)	:	20% Min.		

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