

DIFFUSALLOY 925

A new highly alloyed versatile, low heat input all positional “Lo-Temp” electrode for welding steel like Sandvik 2RK 65, Alloy 20, HV9, Carpenter 20 etc. Has highest resistance to corrosion particularly to reducing atmosphere upto 1200⁰C. Also suitable for welding low alloys steels and for joining different steels to mild steels and low alloy carbon steels.

Applications:

For production and maintenance welding of dairy, food, chemical, cryogenic components, deep freezers, cooling coils of compressors of ammonia, nitrogen gasses etc.

Procedure :

Preheat electrode to 150⁰C to reduce moisture to get best results.

Use electrode on AC / DC+ at lowest possible amps.

Clean weld area and provide clamps / backup plates to minimize distortion on thin plates. Tack-weld at short intervals.

Maintain very short arc and avoid weaving

<u>Technical Data</u>	:	DIFFUSALLOY 925			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	45 – 80	60 – 100	75 – 130	125 - 160
Tensile Strength	:	60 kgf / mm ² (Min.)			
Elongation	:	30% (Min.)			
CVN Impact Strength	:	65J (Min.)			
Tip Colour	:	Light Grey			

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