

DIFFUSALOY ZF AC/DC+

A Specially Coated “ ZERO FERRITE” Stainless steel Electrode for all positional welding of Zero ferrite stainless steels for optimum results & superior resistance to corrosion. It has an excellent resistance to pitting. The deposits are spatter free & slag removal is easy leaving smooth uniformly ripple beads.

Applications:

Specially recommended for chemical plants where corrosion resistance is required against strongly oxidizing or nitrogenous media. Diffusaloy ZF AC/DC+ is fully Austenitic stainless grade 316L developed for urea reactors, Picking Plates etc.

Procedure:

Clean weld area and clamp long seams.

Use back-up plates for minimizing the distortion of thin plates.

Tack weld at short intervals.

Use minimum possible current and chip the slag between passes. Avoid weaving.

<u>Technical Data</u>	:	DIFFUSALOY ZF AC/DC+			
Size (mm)	:	2.0	2.50	3.15	4.00
Recommended Welding Current (Amps)	:	35-45	50-70	80-100	110-140
Tensile Strength	:	53-61 kgf / mm ²			
Elongation	:	35-45 %			
Tip Colour	:	Dark Brown			

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