

DIFFUSALLOY 908 L

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

Applications:

For fabrication and maintenance application involving stainless steels AISI 301, 302, 304, 304 L, 308L of similar composition. Excellent for applications in dairy, Food, chemical industries and nuclear plants. Extra low carbon and low amp aid in minimizing carbide precipitation.

Procedure:

Preheat electrode to 200⁰C 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>	:	DIFFUSALLOY 908 L			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	50 – 70	80 – 100	100 – 130	130 - 160
Tensile Strength	:	53 kgf / mm ² (Min.)			
Elongation	:	35% (Min.)			
Impact Strength at +20 ⁰ C	:	8 -12 kgfm / cm ²			
Coating colour	:	White			
Tip Colour	:	Light Green			

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