

DIFFUSALOY 910

A versatile "Low Temp" all-positional austenitic stainless steel electrode for the welding of stainless steels of the AISI types 309 and 310. Also for dissimilar and unknown austenitic steels and for joining these to steels.

Applications:

Design for elevated temperature applications requiring the high oxidation resistance and high strength temperature up to 1100°C . Ideal for welding furnace parts heat exchangers, heat treatment boxes, kiln cooler plates, and for clad steel.

Procedure :

Clean weld area. Clamp and tack at shorts intervals. Use electrode on AC/DC+ at lower possible amps. Maintain very short arc and cheap slag between passes. Avoid weaving.

<u>Technical Data</u>	:	DIFFUSALOY 910			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	45 – 70	60 – 100	80-135	130 - 175
Tensile Strength	:	57 kgf / mm ² (Min.)			
Elongation	:	30% (Min.)			
Tip Colour	:	Grey			

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