

DIFFUSALLOY 916 L

An Extra Low Carbon “Lo Temp” austenitic stainless steel electrode for all-positional welding of AISI 316,316 L, 317 and 318 stainless steels. Deposits of Diffusaloy 916 L offer superior resistance to intergranular corrosion.

Applications:

For production and maintenance applications in chemical and paper industries, where service conditions demand excellent resistance to pitting and corrosion under strongly oxidizing media. Diffusaloy 916 L being ELC type, minimizes carbide precipitation and thus eliminates intergranular corrosion.

Procedure:

Clean weld area and clamp long seams. Use backup plates to minimize distortion on thin sheets. Track-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 916L			
Tensile Strength	:	55 kgf / mm ² (Min.)			
Elongation	:	30% (Min.)			
CVN Impact Strength at 20 ⁰ C	:	8 – 12 kgfm / cm ²			
Coating Color	:	White			
Tip Colour	:	Dark Brown			
Size (mm)	:	2.5	3.15	4.00	5.00
Recommended Welding Current (Amps)	:	40 – 70	60-100	75-130	125-160

DIFFUSION ENGINEERS LIMITED

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