

DIFFUSALLOY 1301

Description:

Diffusaloy 1301 is a coated aluminium electrode distinguished by good welding properties having excellent arc stability. High strength, versatile alloy gives porosity free deposits, ideal for production as well as maintenance welding. With steady arc it gives dense and poreless seams which are not prone to cracking.

Applications:

For joint and repair weldings on aluminium wrought and cast alloys when a higher strength is required. This alloy is particularly recommended for heat treated aluminium, heavy castings, long joints, repairing cracks, filling holes and building up missing sections, for example overhead water tank, motor end cover etc.

Procedure:

Use DC reverse polarity or electrode positive. In order to avoid shrinkage cracks the complete cast aluminium piece should usually be preheated to 300⁰C. Electrodes that have got damped must be dried to one hour at 100⁰C.

TECHNICAL DATA	:	DIFFUSALOY 1301	
Size (mm)	:	3.15	4.00
Recommended Welding Current (Amps)	:	90 – 120	120 –150
Tensile strength	:	9.8 kgf/mm ² (min.)	
Coating colour	:	White	

DIFFUSION ENGINEERS LIMITED

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