

## DIFFUSALLOY 2535

**DIFFUSALLOY 2535** is a special high recovery electrode depositing a fully austenitic weld metal, with exceptionally high corrosion resistance to a variety of industrial acids. It is well suited for joining and hardfacing on the same or similar stabilized or non-stabilized, fully austenitic and molybdenum and copper based cast steels. It can be used for joining materials like UNS 08028, 904 L and NiCr 21 Mo etc. DIFFUSALLOY 2535 was developed to weld these materials in conjunction with low alloyed type steels as well as intermediate and top plating layers. The deposited overlay leaves a pierce and tension resistant deposit that is also resistant to intergranular corrosion, specially from acids and non oxidating materials, i.e. sulphurous-, phosphorous acids or ammonium- acetate. Operating temperature for weld deposits is from  $-60^{\circ}\text{C}$  up to  $+1200^{\circ}\text{C}$ .

### Applications:

For joining the base materials mentioned above, or as an overlay, in phosphoric acid and sulphuric acid plants, the weld metal has excellent corrosion resistance against many organic acids also. Apart from the high versatile corrosion resistance, the weld metal exhibits a high resistance to stress corrosion cracking, crevice corrosion and pitting in industrial media containing chloride ions.

### Procedure :

Clean weld area. Remove all cracks and fatigued material. Maintain low interpass temperature and medium arc. Chip slag between passes. Use stringer beads when welding dissimilar metals. Re-drying upto  $300^{\circ}\text{C}$  for one hour if required.

<b><u>Technical Data</u></b>	:	<b>DIFFUSALLOY 2535</b>			
Size (mm)	:	2.5	3.15	4.0	5.0
Recommended Welding Current (Amps)	:	60 – 90	90 – 125	130 – 170	170 - 220
Tip Colour	:	Yellow			

### DIFFUSION ENGINEERS LIMITED

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