DIFFUSION
Innovative superconditioning solutions

CORDIFF 309L

Characteristics:

Cordiff 309L is specially developed C-Cr-Ni-Mo stainless steel flux cored wire with high alloying content, which produces bright and smooth bead. Due to higher content of Cr-Ni the weld metal deposit has higher strength and lower susceptibility to cracking. Used for 301, 302, 304, 305, 308 and 309 type stainless steel and also for dissimilar joining. Such as stainless steel to mild steel. Cordiff 309L have stable and smooth arc, with very good slag detachability.

Typical Applications:

For welding and joining of austenitic stainless steel 301, 302, 304, 305, 308 and 309 type stainless steel. Also recommended for tough and wear resistant overlays on all steels. Specially for stainless steel to Mild steel or low alloy steels joining.

Major alloying elements:

C	Si	Mn	Cr	Mo	Ni

Mechanical properties of weld metals:

Tensile strength (kgf/mm^2)	Elongation (%)
60 min.	30 min.

Welding Parameters:

POLARITY: DC + ve
SHIELDING GAS: 80%Ar/Balance CO_2 or 100% CO_2

DIA. (mm)	VOLTAGE	AMPS
1.2	21 – 25	120 - 200
1.6	24 – 27	180 – 230
2.0	25 – 28	220 – 250
2.4	26 – 28	260 – 300
2.8	27 – 30	300 - 340

STANDARD PACKING:
Spool = 15 kgs (± 1kg) Spool = 25 kgs(± 1kg)

DIFFUSION ENGINEERS LIMITED
Regd. Office & Works I : T-5/6, M.I.D.C, Hingna Industrial Area, Nagpur-440 016, (T) 091-7104-232084, 234727 (F) 232085
Works II : N-78/79, MIDC, Hingna Industrial Area, Nagpur – 440 016. (T) 091-7104-236036
Works II : T-12, MIDC, Hingna Industrial Area, Nagpur – 440 016.(T) 091-7104-232984
Email : info@diffusionengineers.com Website : www.diffusionengineers.com
Branch Offices : Chennai, Faridabad, Jamshedpur, Pune, Raipur, Secunderabad, Vadodara.