

## CORDIFF 324

### Characteristics:

Cordiff 324 is specially developed C-Cr-Ni-Mo stainless steel flux cored wire with high alloying content, which produces bright and smooth bead. Chemistry is so controlled; the ferrite-austenite duplex structure provides resilience with very high strength. Due to higher content of Cr-Ni the weld metal deposit has higher strength and lower susceptibility to cracking. Used for stainless steel and also for dissimilar joining. Such as stainless steel to mild steel. Cordiff 324 have stable and smooth arc, with very good slag detachability.

### Typical Applications:

High strength, crack resistant joining of unknown and dissimilar steels, Hadfield High Carbon and alloy steels. Also recommended for tough and wear resistant overlays on all steels.

For welding and joining of austenitic stainless steel and other steel. Also recommended for tough and wear resistant overlays on all steels. Especially for stainless steel to Mild steel or low alloy steels joining.

### Major alloying elements:

<b>C</b>	<b>Si</b>	<b>Mn</b>	<b>Cr</b>	<b>Mo</b>	<b>Ni</b>
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### Mechanical properties of weld metals:

<b>Tensile strength (kgf/mm<sup>2</sup>)</b>	<b>Elongation (%)</b>
<b>70 min.</b>	<b>15 min.</b>

### Welding Parameters:

**POLARITY:** DC + ve

**SHIELDING GAS:** 80%Ar/Balance CO<sub>2</sub> or 100% CO<sub>2</sub>

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

### **STANDARD PACKING:**

**Spool = 15 kgs (± 1kg) Spool = 25 kgs(± 1kg)**

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