



Typical Properties:

Undiluted Weld Metal

Tensile strength
Yield strength
Elongation
Impact Energy

Maximum Value up to:

88,000 psi (630 N/mm²)
80,000 psi (570 N/mm²)
28%
70J: -4°F (-20°C)

Flux Color: Brown

Recommended Current: DC Reverse (+) or AC

Recommended Amperage Settings:

Diameter (mm)	1/8 (3.25)
Minimum Amperage	35
Maximum Amperage	125

Welding Position: Flat, Horizontal, Vertical Up, Vertical Down, Horizontal, Overhead

Deposition Rates:

Diameter (mm)	Length (mm)	Weldmetal/ Electrodes	Electrodes per lb (kg) of Weldmetal	Arc Time of Deposition Min/lb (kg)	Amperage Setting
1/8 (3.25)	14" (350)	.56oz (15g)	25 (56)	25 (56)	80

Welding Techniques: Weld with short-medium arc length at low amperage. When surface preparation is impractical, use a medium-long arc and favor high amperages. Multi-pass welds can be made without intermittent slag removal. Use any welding technique from stringer bead to wide weave.

Electrode Packaging & Dimensions

Diameter (mm)	1/8 (3.25)
Length (mm)	14" (350)
Electrodes/lb	18
Electrodes/kg	40

DIABLO