

Eutec - StainTrode D

Manual Metal Arc Electrode For Unknown Grades Of Stainless Steel And Refractory Steels.

DESCRIPTION

Eutec - StainTrode D is a versatile, low heat input manual metal arc electrode designed for maintenance welding of stainless steels, particularly for unknown grades and refractory steels. It is engineered for high-speed welding, minimizing distortion, and providing easy slag removal and moisture resistance.

Product Details

- Immediate striking and re-striking -ideal for tacking applications.
- Resistance to inter granular corrosion -maximum safety margin.
- Refined grain micro structure - increased performance.
- Insensitive to hydrogen embitterment - increased reliability.
- Resistant to embitterment at cryogenic or furnace temperatures
- Resistant to heat and oxidation up to 1100 C.

APPLICATIONS:

Suitable for assembly and repair of AISI 309 20/25) 310 ,(12/25)), and 314 type refractory steel. Ideal for applications requiring excellent resistance to heat and corrosion like burner pipe, Kiln anchor welding.

PROCEDURE FOR USE

Preparation: Ensure that all areas to be welded are free from oxides, contaminants, etc. Adopt suitable joint preparation for repair and fabrication applications.

Preheating: Preheating is not generally necessary when welding austenitic stainless steels. For overlaying operations on ferritic steels, preheating of the steel section may be necessary depending upon type and size.

Welding procedure: Employ short arc length and near vertical electrode angle. Ensure that each weld pass is thoroughly cleaned and that all slag residues are removed. Thin sections may require tack welding procedure and a welding technique in order to reduce distortion effects. Avoid stray arcing outside the weld preparation.

TECHNICAL DATA

Tensile strength : 630 N/mm² (91,000 psi)

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	45-70
3.2mm	60-100
4.0mm	80-130

Note: For optimum result use the lowest amperage practical