

Eutec - StainTrode A-Mo-L

Premium stainless steel electrode for maintenance and repair welding of Austenite Stainless steel grades

DESCRIPTION

StainTrode A-Mo-L is a high chromium-nickel electrode formulated with a highly refined flux coating for all-position welding of stainless steels. Arc control is outstanding and slag is virtually self-releasing. This premium stainless steel electrode is ideal for welding molybdenum- enhanced stainless steels such as AISI 316 ,316L, 317, and 317L. It can also be used on non- molybdenum bearing stainless steels such as AISI 304 ,304 ,302 ,301L and 321. Exhibits enhanced corrosion resistance due to increased levels of molybdenum

Product Details

- Enhanced corrosion and pitting resistance due to increased levels of molybdenum
- Formulated for use on dairy, food and distillery equipment
- Designed for welding molybdenum enhanced stainless steels such as AISI 316, 316L, 317 etc

APPLICATION

- Pasteurizers in Dairy, Chemical Vats, Pulp Digesters in Pulp and Paper mills
- Settling Tanks : Water Treatment/Food Processing
- Plating Baskets : Manufacturer of Metal Products
- Boiler Pumps: Various Industries

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. Make sure all oily contaminants are removed with a suitable VOC-free cleaner. Angle preparing normally involves close butts and infrequently bevel preparations. If needed, a 60° V bevel is acceptable. Preheating of stainless steels is generally not required.

TECHNIQUE: A short, non-contact technique is recommended for both fillet and butt- welding. Use a slightly longer arc-length for bead-on plate welding. Deposit stringer beads or 2 times to 3 times weave beads. Do not weave more than three times the electrode diameter otherwise excessive heat input will cause distortion.

POST-WELDING: Allow parts to cool naturally in ambient condition

Property

Tensile strength: 620 N/mm² (90,000psi)

Current polarity: AC/DC (+)

DIAMETER	AMPERAGE
2.5mm	65-80
3.2mm	85-105
4.0mm	90-140

Note: When using StainTrode A-Mo-L keep to the low end of the amperage range for optimized