

Eutec - StainTrode B-L

Low Carbon Stainless Steel Electrode With Excellent Heat And Corrosion Resistance For Joining And Overlay Applications.

DESCRIPTION

Eutec - StainTrode B-L is a versatile manual metal arc electrode, low heat input, all position electrode. High corrosion and heat resistance electrode for manual arc welding 18/8 and 19/9 stainless steel type 301,302,304,304L,305,306,308,308L and 347.

Product Details

All positions electrode. Especially recommended for joining extra low carbon grades to minimize carbide precipitation and eliminate inter granular corrosion, where good corrosion resistance are required. Excellent resistance to heat and scaling.

APPLICATIONS:

Containers, mixers, chemical plant equipments, distillery equipments, food processing equipments and also for protective overlay on steel,

TECHNICAL DATA

Tensile strength : 560 N/mm²(80,000 psi)

Current polarity: AC/DC (+)

PROCEDURE FOR USE

Clean weld area. Thickness upto 3 mm can be square butt welded. Heavier sections should be beveled to a 60°angle. Tack at short intervals to maintain alignment. Hold electrode at a 15° angle in the direction of travel. Maintain a short arc. Stringer beads are preferable. Clean slag between passes. Use a number of light beads. Use skip or step back technique.

DIAMETER	AMPERAGE
2.5mm	40-70
3.2mm	70-100
4.0mm	90-140

Note: For optimum result use the lowest amperage practical