



Agitator Shaft

**Low carbon stainless steel electrode for joining and overlaying applications with excellent heat and corrosion resistance property.**

#### **Typical Applications:**

Containers, mixers, chemical plant equipment, equipment for food processing.

#### **Outstanding Features:**

- Low heat input.
- All position.
- Excellent colour match.
- Extra low carbon.

#### **Recommendation:**

All-purpose electrode with high corrosion and heat resistance for metallic arc welding 18/8 and 19/9 stainless steel, types 301, 302, 304, 304L, 305, 306, 308 and 347, in all positions. Especially recommended for joining extra low carbon grades to minimize carbide precipitation and eliminate intergranular corrosion. Applicable for dairy, chemical and distillery equipment. Ideal as a protective overlay on steel, where good corrosion resistance is required. Excellent resistance to heat and scaling.

#### **Procedure:**

Clean weld area. Thickness up to 10mm can be square butt welded. Heavier sections should be bevelled to 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. Use electrode positive with DC machine. Minimum open circuit voltage for AC: 55V.

#### **Recommended Amperages:**

| Size (mm) | Amperage |
|-----------|----------|
| 2.50      | 40 - 70  |
| 3.15      | 70 - 100 |
| 4.00      | 90 - 140 |

**Tensile Strength:** 58 Kg/mm<sup>2</sup>  
(82,000 psi)