

# Stainless Steel

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# 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 intergranular corrosion -maximum safety margin.
- Grain refined microstructure -increased performance.
- Insensitive to hydrogen embrittlement -increased reliability.
- Resistant to embrittlement 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/mm<sup>2</sup>(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

# Eutec - StainTrode A-MO-L

## Premium Stainless Steel Maintenance And Repair Electrode For Welding

### DESCRIPTION

StainTrode AMoL 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 and 316L

### 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

### Property

Tensile strength: 620 N/mm<sup>2</sup>  
(9 0,000 psi)

Current polarity: AC/DC (+)

### 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 prepping normally involves closebutts 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 still air

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

Note: When using StainTrode AMoL, keep to the low end of the amperage range for optimized

# 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 metallic 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 intergranular 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/mm<sup>2</sup>(80,000 psi)

Current polarity: AC/DC (+)

## PROCEDURE FOR USE

### Procedure:

Clean weld area. Thickness upto 10 gauge 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