

Eutec-StainTrode D<sub>ac / dc+</sub>

Coal Burner Nozzle

Excellent electrode for joining wide range of SS and MS base metal for oxidation and heat resistance applications

#### Typical Applications:

Valves, tanks, heat exchangers, heat treating boxes and baskets.

#### Outstanding Features:

- Ideal for oxidation and heat resistance.
- Ideal for joining of stainless steel of unknown composition.
- Smooth, rapid, spatter-free deposition.

#### Recommendation:

Excellent weldability, no spatter, high strength and elongation for 25/20 type stainless steel and other unknown stainless steels. Designed for applications requiring a high degree of oxidation resistance and high strength at temperatures up to 1000°C. Used also for welding stainless steel to mild steel.

#### Procedure:

Clean weld area. Tack at short intervals when jigs are not available. Square butt weld thickness upto 10 gauge. Heavier sections should be bevelled 60°. Maintain short arc and deposit stringer beads. Avoid weaving. Deposit a number of light beads. Use an intermittent welding sequence to prevent overheating. Remove slag. Use electrode positive with DC machine. Minimum open circuit voltage for AC :55 V.

#### Recommended Amperages:

Size (mm)	I - Range	II - Range
2.50	60 - 70	40 - 50
3.15	85 - 100	55 - 75
4.00	115 - 135	80 - 105

Tensile Strength: 66 kg/mm<sup>2</sup>  
(95,000 psi).