

Stain-Plus™

Low-Amperage Stainless Steel Electrode

Stain-Plus is a high-strength stainless steel electrode offering high corrosion and pitting resistance in harsh environments.

- Low amperage — reduces discoloration, distortion and burn-through
- Spray arc type transfer — produces a smooth, finely rippled uniform deposit with no spatter or undercutting
- Versatile — designed for all-position welding and formulated for most common austenitic stainless steel (200-300 series)*
- Oxidation resistant — to 1800°F/982°C



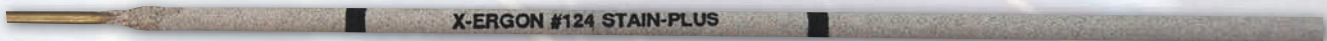
SPECIFICATIONS

Tensile strength.....	82,000 psi/565 MPa
Yield strength.....	50,000 psi/345 MPa
Hardness.....	82 Rb
Elongation.....	40%
Machinability.....	Excellent
Heat resistance up to 1800°F/982°C.....	Excellent
Corrosion resistance.....	Excellent
Color match.....	Excellent
Current.....	DCEP (DC+) or AC



PROCEDURE

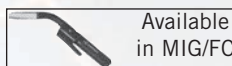
Remove contaminants before welding. Remove defective metal by gouging or grinding. Use short arc length and stringer beads. Minimum amperage recommended. Do not overheat. 300 series stainless can be cooled with wet rags.



APPLICATIONS

- Food processing industry
- Drug manufacturing
- Soap manufacturing
- Fertilizer plants
- Valve repair shops
- Petroleum industry
- Bakeries
- Power industry
- Dairies
- Hospitals
- Heating and cooling industry
- Paints and coatings industry
- Cosmetics manufacturing
- Salt mines
- Electrical motor repair shops
- Chemical industry
- Marine industry
- Breweries
- Beverage processing industry
- Creameries

Code #	Diameter	Amperage
124-3-0000	5/32"	100-145
124-4-0000	1/8"	70-110
124-5-0000	3/32"	45-80
124-6-0000	5/64"	30-65



*Not recommended for high moly grades or stabilized grades of 300 series stainless (i.e.: 317, 318, and 320, 330, 340 series).