

Stain-Plus™ Easy-Down™ Vertical Down Stainless Steel Electrode



Stain-Plus Easy-Down is the first maintenance all-position stainless electrode specifically formulated to weld vertical down.

- Controlled penetration — softer arc minimizes weld spatter and virtually eliminates burn-through on thin metals
- Time saving — vertical down welding increases welding speed by 50%
- Minimum distortion — less heat input reduces the risk of distortion on thin gauge stainless
- Excellent arc stability even on AC
- Superior all-position characteristics
- Designed to weld most 200 and 300 series stainless steels*.



SPECIFICATIONS

Tensile strength.....	82,000 psi/565 MPa
Yield strength.....	50,000 psi/345 MPa
Hardness.....	82 Rb
Elongation.....	40%
Machinability.....	Excellent
Heat resistance.....	Excellent up to 1800°F/982°C
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. For welding vertical down, maintain a short arc. Use fast travel speed and maintain an upward angle with the electrode. Remove slag between passes.



APPLICATIONS

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|--------------------------|-------------------|-----------------------------|
| • Stainless steel pipe | • Tubing | • Fittings |
| • Sheet metal | • Dairies | • Pulp and paper processing |
| • Food processing | • Chemical plants | • Refineries |
| • Power plants | • Hospitals | • Grounds maintenance |
| • Tank trucks | • Beverage plants | • Agricultural equipment |
| • Fertilizer applicators | | |

Code #	Diameter	Amperage
126-4-0000	1/8"	105-115
126-5-0000	3/32"	50-70
126-6-0000	5/64"	30-60

DOD EMALL
<https://dod.emall.dia.mil>
 SP47W1-17-D-0009
 Available in select sizes only

For kits see page 6

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