



Industrial Grade Maintenance
Electrode for Welding Molybdenum-
Bearing Stainless Steels

EutecTrode®

53L



- Enhanced corrosion and pitting resistance due to increased levels of molybdenum
- For use on dairy, food and distillery equipment
- Ideal for welding molybdenum enhanced stainless steels such as AISI 316 and 316L

EutecTrode® 53L

EutecTrode 53L is a Cr Ni Mo electrode formulated with a flux coating for all-position welding of stainless steels. Arc control is outstanding and slag is virtually self-releasing. This stainless steel electrode is ideal for welding molybdenum-enhanced stainless steels such as AISI 316 and 316L. It can also be used on non-molybdenum bearing stainless steels such as AISI 301, 302, 304 and 304L. EutecTrode 53L exhibits enhanced corrosion resistance due to increased levels of molybdenum.

TECHNICAL DATA

Typical Values	
Tensile Strength:	80,000 psi
Yield Strength:	58,000 psi
Elongation (1=5d) min.:	45% at room temperature
Hardness as-deposited:	BHN 210
Impact Strength:	Charpy V 40 ft-lbs. at -150°F
Ferrite Content (Magna Gauge Value):	Between 5 and 10%

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)
AMPERAGE	65-80	85-105

Note: for optimum results use the lowest amperage practical

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 close-butts and infrequently bevel preparations. If needed, a 60° V bevel is acceptable. Pre-heating 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 2x to 3x 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.

TYPICAL APPLICATIONS

APPLICATIONS:	INDUSTRY:
Pasturizers	Dairy
Chemical Vats	Various Industries
Pulp Digesters	Pulp & Paper
Settling Tanks	Water Treatment
Plating Baskets	Metal Manufacturing
Boiler Pumps	Various Industries



Eutectic Corporation:
N94 W14355 Garwin Mace Dr.
Menomonee Falls WI, 53051 USA
+1 800. 558. 8524 • eutectic.com

Eutectic Canada:
428, rue Aimé-Vincent Vaudreuil-Dorion,
Québec J7V 5V5 Canada
+1 800. 361. 9439 • eutectic.ca



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