



Premium Stainless Steel Maintenance
and Repair Electrode for Welding
Molybdenum-Bearing Stainless Steels.

StainTrode®

AMoL



- 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

StainTrode® AMoL

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 301, 302, 304, 304L and 321. Exhibits enhanced corrosion resistance due to increased levels of molybdenum.

TECHNICAL DATA

Typical Values	
Tensile Strength:	90,000 psi (620 N/mm ²)
Yield Strength:	62,000 psi (430 N/mm ²)
Elongation:	45% at room temperature 40% at 550°F
Hardness:	210 BHN
Impact Strength (Charpy V):	40 ft - lbs at -150°F
Ferrite Content:	Magna Gauge Value between 5 - 10%
Current & Polarity:	AC or DCEP (+)

SUGGESTED WELDING PARAMETERS:

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

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

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. 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 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.

TYPICAL APPLICATIONS

APPLICATIONS	INDUSTRY
• Pasteurizers	Dairy
• Chemical Vats	Various Industries
• Pulp Digesters	Pulp and Paper
• Settling Tanks	Water Treatment/Food Processing
• Plating Baskets	Manufacturer of Metal Products
• Boiler Pumps	Various Industries

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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



Follow Us On...

