



Premium Stainless Steel  
Maintenance and Repair Electrode

# StainTrode® D



- Ideal for welding dissimilar stainless steels and steels of unknown composition
- Welds stainless steels to carbon steels
- High heat applications

# StainTrode D

StainTrode D is an enhanced chromium-nickel electrode formulated to weld dissimilar stainless steels and stainless steels of unknown composition. Its chemistry is enriched for use with AISI grade 310. This premium stainless steel electrode is easily handled and has very good scaling and oxidation resistance up to 2100° F.

## TECHNICAL DATA

### Typical Values

Hardness as-deposited:	BHN 190
Elongation:	35% at room temperature
Tensile Strength:	95,000 psi (655 MPa)
Yield Strength:	64,000 psi (440 MPa)
Impact Strength:	Charpy V: 35 ft-lbs at -150°F
Ferrite Content:	Fully austenitic
Current & Polarity:	AC or DCEP (+)

DIAMETER	3/32" (2.4mm)	1/8" (3.2mm)	5/32" (4.0mm)
AMPERAGE	65 - 80	85 - 105	115 - 135

## 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 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

- Boiler Baffles
- Sponge Iron Kilns
- Radiant Tubes
- Annealing Covers
- Refractory Anchor Bolts



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