



## AMTEC STAINFER 316L STAINLESS STEEL AC/DC REVERSE ELECTRODE

### General Characteristics

Amtec Stainfer 316L is an economical, fully synthetic, high performance, joining and cladding stainless steel alloy for use on a variety of stainless steels. Stainfer has very high speed weld deposition and easy striking. It produces clean, spatter free welds and the slag lifts by itself. It has an extra low carbon content, suitable for welding CR-NI-MO steels in the 300 series, such as 316L. The loaded flux and mild steel core wire keep the electrode from overheating, and the electrode deposits much more than conventional type stainless electrodes. The 1/16 and 5/64 sizes are very popular for welding out of position and for stainless steel pipe welding.

### Procedure

As with all stainless steel electrodes, it is important to clean the weld area thoroughly, preferably using a solvent or emulsifier to remove all grease, fats, or oils. Preheating is generally not required. Sections up to 3 mm (1/8 inch) thick can usually be welded with a close joint. Heavier sections should have 60-70° included Vee preparation. Tack long seams to maintain alignment, clamp thin parts to chill bars if possible. Hold the electrode in a vertical position using a short arc. Use lower currents for thin work to limit distortion. Adjust speed to accommodate high deposition rate, which is about 2 times that of a conventional stainless steel electrode.

### Application

Amtec Stainfer 316L is used for welding and cladding stabilized and unstabilized stainless steels to themselves and to carbon steel. For use on pickling tanks, pumps, piping systems, dairy vessels, and food and drug equipment. This electrode can also be used in production applications where speed is required. Has 180% metal recovery. Conforms to AWS 316L-16 specifications.

<b>Tensile Strength</b>	<b>107,000 PSI</b>
<b>Yield Strength</b>	<b>75,000 PSI</b>
<b>Elongation</b>	<b>36%</b>
<b>Hardness (HB) (as deposited)</b>	<b>approx. 190</b>
<b>Impact Strength</b>	<b>40J: -105°C</b>

<b>Diameter (Inch)</b>	<b>1/16</b>	<b>5/64</b>	<b>3/32</b>	<b>1/8</b>
<b>(mm)</b>	<b>1.5</b>	<b>2.0</b>	<b>2.5</b>	<b>3.25</b>

<b>Amps (approx.)</b>	<b>30-40</b>	<b>50-75</b>	<b>65-100</b>	<b>90-145</b>
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CONFIDENTIAL INFORMATION  
Subject to change without notice

Tip Color – Yellow  
Stainfer 316L Impregnated