

**AMTEC 316L VERTICAL DOWN STAINLESS STEEL
AC/DC REVERSE ELECTRODE**

General Characteristics

Amtec 316L Vertical Down Stainless Steel electrode is a specially coated welding electrode with an extreme fast freeze flux coating that allows this electrode to be used in the Vertical Down position. It is ideal for poor fit up joints in all positions. The controlled weld puddle allows for filling holes on stainless steel.

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 and oils. Preheating is generally not necessary. For vertical welding, set amperage at high end of recommended setting. Maintain a sharp angle with electrode pointing upward. Whip the electrode quickly back and forth while moving up or down. The electrode may start to show a red color from the excess amperage which is normal for these type of electrodes.

Application

Amtec 316L Vertical Down is especially suited for vertical down and up welding of thin to medium gauge molybdenum bearing stainless steels. The microstructure is an austenite with 3-9% ferrite. The typical ferrite is 6%. Besides Vertical up and down, this electrode may be used Flat, Horizontal, and Overhead.

Tensile Strength	80,000 PSI
Yield Strength	56,000 PSI
Elongation	42%
Hardness (HB) (as deposited)	approx. 209
Impact Strength	40J: -105°C

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

Amps (approx.)	30-40	35-55	60-80	90-110
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CONFIDENTIAL INFORMATION
Subject to change without notice

Tip Color – Plain
316L Vertical Down Imprint