

Stainless Steel SMAW Electrodes

Welding Notes

1. Recommending low electrical current (low heat input and low dilution rate) of avoiding sensitization due to carbonate chromium precipitation in the HAZ (Heat Affected Zone).
2. To control the welding current within the recommended range for avoiding of core wire overheat and coating peeling off.
3. Short arc welding technique to prevent N_2 and O_2 into arc creating blow hole and alloy elements burning loss, excessive spatter occurrence and detrimental of weld metal microstructure.
4. To keep weaving width 3 times of core wire diameter as maximum while necessary.
5. Recommending to use jigs, fixtures or proper welding sequence to limit welding deformation.
6. 200~250°C x 1 hr baking prior to use. Proper cleaning of welding groove or joint surface before welding and complete removal of spatter after welding.
7. To follow welding parameter described in welding procedure specification (groove type, weldment thickness, welding current and voltage range, etc) to guaranty the quality.
8. Recommending pre-heat and inter-pass temperatures table :

Steel Type	Pre-heat Temperature	Inter pass Temperature
Austenite Type	15°C (60°F)	150°C (300°F)
Martensite Type	200°C (400°F)	310°C (600°F)
Ferrite Type	150°C (300°F)	260°C (500°F)

9. The polarity illustration :
DCEP (DC+): Electrode positive or DC reverse polarity.
DCEN (DC-): Electrode negative or DC straight polarity.