

WELDING PRODUCTS

Application Guide For 300 Series Alloy

Stainless Steel Stick Electrodes



Product Description	Sandvik -16 Electrodes	Sandvik -17 Sanspray Electrodes	Sandvik Platinum "P" Series Electrodes
AWS Classification	3XX -16	3XX -17	3XX -17
Intended Applications	ALL PURPOSE General purpose welding in fabrication, for better penetration and joint strength, pressure vessels, heat exchangers, etc..	DOWNHAND, FLAT General purpose welding and repair in light fabrication and production, heat exchangers, small overlay applications.	VERTICAL UP & DOWN Light fabrication, pipe welding, field repairs, thin gauge materials in all positions, and for poor fitups.
Recommended Weld Positions	Flat, Horizontal, Overhead, Vertical Up	Flat and Horizontal only	Flat, Horizontal, Overhead, Vertical Up, Vertical Down
Standard Alloys Available (Other alloys available upon request)	308L, 308H, 309L, 309, 310, 312, 316L, 316H, 317L	308L, 309L, 316L, 347, 2209 (duplex)	308L, 309L, 309MoL, 316L, 317L, 2209
Operating Characteristics	Excellent arc stability, low spatter, smooth uniform beads, works in any standard weld position.	Fast burn off rate with minimal stub loss, improved moisture resistance, easy weld puddle manipulation, self peeling slag, easy post weld finishing.	Smooth overall operation in all positions, excellent in vertical down, perfect for poor fit ups and bridging small gaps, easy slag removal and clean up.

Product Description	Sandvik –16 Electrodes	Sandvik Sanspray Electrode	Sandvik Platinum “P” Series
Diameters Available and Recommended Operating Parameters (Diameter Volts Amps)	Dia. (Unit/Carton) Volts Amps 2.5mm (7/21#) 24–26V 70–80A (~3/32) 3.25mm (9/27#) 24–26V 90–110A (~1/8) 4.0mm (10/30#) 24–26V 135–145A (~5/32) 5.0mm (10/30#) 22–24V 165 – 175A (~3/16)	Dia. (Unit/Carton) Volts Amps 2.5mm (7/21#) 30-32V 45-85A (~3/32) 3.25mm (9/27#) 30-32V 60-130A (~1/8) 4.0mm (10/30#) 30-32V 90-200A (~5/32) 5.0mm (10/30#) 30-32V 145-220A (~3/16)	Dia. (Unit/Carton) Volts Amps 2.0mm (6.6/19.8#) 20V 16-35A (~5/64 in.) 2.4mm (6.6/19.8#) 21V 18-45A (~3/32) 3.2mm (7.7/23.1#) 23V 35-90A (~1/8) 4.0mm (7.7/23.1#) 25V 45-110A (~5/32)
Current (polarity)	AC/DCEP	AC/DCEP	DCEP/DCEN
ADDITIONAL FEATURES and CHARACTERISTICS Coating Type Core Wire Chemistry Beadshape Penetration Metal Transfer Slag Removal Restrike Charpy Impact Values Reconditioning Holding Material Certification Available Specifications Technical Datasheets Packaging Mfg. Certification Origin	Rutile (acidic) Fully alloyed Flat Moderate Globular Easy Easy Poor 500 – 600F for 3 hours 225 – 300F Actual weld chemistry AWS, ASME, CWB, ASME Section III Available (see website) Hermetically sealed plastic capsule with replaceable plastic cap. ISO-9002 Made in Sweden	Rutile (acidic) Fully alloyed Concave Shallow Spray Very easy Easy Poor 500 – 600F for 3 hours 225 – 300F Actual weld chemistry AWS, ASME, CWB, ASME Section III Available (see website) Hermetically sealed plastic capsule with replaceable plastic cap. ISO-9002 Made in Sweden	Rutile (acidic) Fully alloyed Flat Shallow Spray Very easy Easy Poor 500 – 600F for 3 hours 225 – 300F Actual weld chemistry AWS Available by request Hermetically sealed can with replaceable plastic cap. ISO-9002 Made in Sweden
Compare To:	Lincoln Red Baron, ESAB Arcalloy – 16, Techalloy –16, Hobart Smootharc Plus, Arcos -16	Lincoln Blue Max, McKay Sterling, MG Slikstick, Hobart Smootharc, Arcos-17	Avesta VDX, Bohler/Thyssen

For additional information including technical and MSDS data, please visit our website at www.steel.sandvik.com/us

Welding Hotline for TECHNICAL SUPPORT – call 800-781-9449

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