

DATASHEETS

Datasheets for all grades of Sandvik SANSPRAY electrodes are available by requesting our Covered Electrode Catalog.

APPLICABLE STANDARDS, SPECIFICATIONS, OR APPROVALS

ASME Sec II SFA 5.4 (ASME Sec III available by request)

ANSI

AWS 5.4

AWS SFA 5.4

CWB

APPLICATIONS

Sandvik SANSPRAY electrodes are of special interest to fabricators of heat exchangers and food processing equipment which often require concave /flat smooth weldbeads. Fast burnoff rate with minimal stub loss even at high current make these electrodes ideal for casting repair. Low penetration into the base metal make this type electrode the preferred choice for small overlay applications or overlay repair. Easy restriking of these electrodes make them well suited for spot welding and tacking. Their superior flow characteristics make wide root gaps easier to bridge.

AWS Specification AWSA 5.4 recognizes three coating (flux) types for stainless steel electrodes identified as type -16, -17, and -15.

CHARACTERISTICS OF -15, -16, AND -17 TYPE ELECTRODES

	-16 Type	SANSPRAY -17 Type	-15 Type
COATING	Rutile(acidic)	Rutile(acidic)	Lime(basic)
POSITION	All	Flat	All
APPLICATION	General	General	Pipe & Cryogenic
BEADSHAPE	Flat	Concave	Convex
PENETRATION	Moderate	Shallow	Deep
TRANSFER	Globular	Spray	Globular
SLAG REMOVAL	Easy	Easy	Hard
CURRENT	AC/DCEP	AC/DCEP	DCEP
VOLTAGE	22-24	28-32	22-24
IMPACTS	Poor	Poor	Good
RESTRIKE	Easy	Easy	Hard
FULLY AUSTENITIC	Available	Not Available	Available

300-17 Series Electrodes

PRODUCT DESCRIPTION

Continuous Improvement of Sandvik "Spray Arc" Electrodes has led to our new SANSPRAY electrodes with improved moisture resistance and even easier slag removal. These electrodes are classified as AWS "-17" type which are intended for general purpose welding in the flat position.

Sandvik SANSPRAY electrodes are made in the USA under ISO9002 Certified Quality System.

FEATURES & BENEFITS

Feature	Benefit
Spray Transfer	Allows drag technique, easy restrike and a wide operating range of current
Concave Beadshape	Welds requiring very little post weld finishing
No Overheating	Longer weld beads with less stub loss
Excellent Wetting	Easier weld puddle manipulation
Fully Alloyed Core	Tight control of Chemistry and Ferrite to optimize corrosion and cracking resistance
Actual Weld Chemistry	No typical certifications

OPERATING RANGE

Size	Amperage	Voltage
3/32 x 12	45-85	30-32
1/8 x 14	60-130	30-32
5/32 x 14	90-200	30-32
3/16 x 14	145-220	30-32

HANDLING, STORAGE AND RECONDITIONING

Sandvik SANSPRAY electrodes are packed in hermetically sealed steel cans. Opened cans should be kept in a Hot Rod Oven at 225-300°F. Electrodes may be reconditioned at 500-600°F for a minimum of 3 hours.

PACKAGING

- 1/16, 5/64- 6lb. cans/ 8 cans per carton
- 3/32- 8lb. cans/ 6 cans per carton
- 1/8, 5/32, 3/16- 10lb. cans/ 6 cans per carton

STANDARD ASSORTMENT

- 308/308L, 308/308H
- 309/309L, 309
- 309MoL
- 316/316L, 316/316H
- 317L
- 347
- Sandvik 29/9 (312 type for Maintenance and Repair type welding)
- 2209 (Duplex)

Other grades may be available as special order. Call 1-800-359-9442 for details

TECHNICAL SUPPORT

For Technical Support for these or any other Sandvik Welding Products call our Welding Hotline at **1-800-781-9449**.

SANDVIK WELDING PRODUCTS ASSORTMENT

- MIG Wire - 300, 400 series, Nickel Base and Special Purpose Alloys.
- TIG Wire - 300, 400 series, Nickel Base and Special Purpose Alloys.
- SUB ARC Wire - 300, 400 series, Nickel Base and Special Purpose Alloys.
- 300-16 Type Stick Electrodes - all purpose.
- 300-15 Type Stick Electrodes - all purpose.
- Nickel Base Stick Electrodes
- Flux Cored 300 T0-1/300 T0-4 - for flat or horizontal welding.
- Flux Cored 300 T1-1/300 T1-4 - for all position welding.
- Strip Electrodes - for weld surfacing materials >1 inch thick.
- Strip Fluxes - Submerged Arc or Electroslag for Surfacing.
- Wire Fluxes - Submerged Arc for Joining or Surfacing.

Ask for publication S2330-US for our complete Sandvik welding products assortment.



We make Quality happen...

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