

GOLD 601 -E FOR STAINLESS STEELS

Description and Applications:

Highly alloyed , easy to weld **stainless steel maintenance electrode., for welding 18/8 grade (304, 304L, 321,347) UGINOX 18-9 B,D,E M and similar stainless steels.**

Suitable for service temperatures of -120°C to 350°C .

Used in food-, brewing-, pharmaceutical -, chemical -, petro-chemical - industries, in water treatment, for tanks, pumps, mixers turbine blades etc.

For joining and overlaying of food processing and dairy equipment, pipes tanks etc.

-No spatter, no overheating, excellent weld ability.

-Fully austenitic deposit

-Can be welded at low amperages reducing heat damage and distortion.



Mechanical properties

Up to:

Packaging Data

Rm (MPa) ≥540	Rp0,2 (MPa) ≥360	A5 (%) ≥35
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Sizes	2.5x300	3.2x350	4.0x450
Kgs/ Packet	4	4,5	5,5
Packets/ carton	4	4	4
Kgs/ carton	16	18	22

HINTS:

Current (A) DC+,AC OCV 70	70	100	130
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Welding positions



Recommendations for stainless steel welding:

Clean weld area. Bevel heavy sections 60° - 90° Vee

Select lowest possible amperage

Weld with stringer beads and use short arc. Remove slag between passes

Use only stainless steel brushes to clean welds

Use staggered weld sequence to balance heat input. For maximum corrosion resistance remove discoloration by brushing or pickling