



A Universal High-Quality Electrode for
Welding a Wide Variety of Stainless Steels

EutecTrode® 4057



- Versatile, all-position stainless steel electrode
- Maintains properties up to 2000°F
- Excellent crack resistance

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EutecTrode 4057 is formulated for all-position welding of a selected range of stainless steels. It is particularly resistant to intergranular corrosion due to its low carbon content. Ideal alloy when welding stainless steels to low, and medium carbon steels. Arc control is welder-friendly and slag release is virtually self-releasing.

TECHNICAL DATA

Typical Values	
Tensile Strength:	80,000 psi (551 N/mm ²)
Yield Strength:	57,000 psi (393 N/mm ²)
Elongation (1=5d):	40% @ room temperature 22% @ 600°F
Hardness	210 BHN
Impact Strength (Charpy V):	35 ft - lbs at -150°F
Current & Polarity:	DCEP (+) or AC

SUGGESTED WELDING PARAMETERS:

Diameter	Amperage
3/32" (2.4mm)	65 - 80
1/8" (3.2mm)	85 - 105

Note: When using EutecTrode 4057 weld at the low-end of the amperage range for best results.

PROCEDURE FOR USE

PREPARATION: Clean weld area of scale and/or oxide. Make sure all oily contaminants are removed with a suitable VOC cleaner. Angle prepping normally involves close-butts and infrequently bevel preparations. If needed, a 60° V bevel is acceptable. Pre-heating of stainless steels is generally not required.

TECHNIQUE: A short, non-contact technique is recommended for both fillet and butt welding. Use a slightly longer arc length for bead-on-plate welding. Deposit stringer beads or 2x to 3x weave beads. Do not weave more than three times the electrode diameter otherwise excessive heat input will cause distortion.

POST-WELDING: Allow parts to slow cool in still air.

TYPICAL APPLICATIONS

- Petro-Chemical Industry
- Food Processing Facilities
- Milk Processing Parts & Assemblies
- Distilleries

Observe normal welding practices, respiratory protection and proper air flow pattern advised. For general welding practices, see AWS publications Z49.1 "Safety in Welding and Cutting and Allied Process". Welding is a completely safe process when performed in accordance with proper safety measures. Become familiar with local safety regulations before beginning welding operations. DO NOT operate welding equipment or use welding materials before you have thoroughly read the proper instruction manual(s). Please refer to the Eutectic internet site for Material Safety Data Sheet (MSDS) information. DISREGARDING THESE INSTRUCTIONS, AND/OR THE INSTRUCTIONS OF WELDING EQUIPMENT OR MATERIAL MANUALS, MAY BE HAZARDOUS TO YOUR HEALTH.



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