



Premium Maintenance  
and Repair Electrode for Welding  
Molybdenum-Bearing Stainless Steels.

# **StainTrode®**

## **BMoL**



- Improved corrosion and pitting resistance due to increased levels of molybdenum
- Resistance to inorganic and organic acids
- Designed for welding molybdenum enhanced stainless steels such as AISI 317 and 317L

# StainTrode® BMoL

StainTrode BMoL is a high chromium-nickel electrode formulated with increased molybdenum and low carbon for improved pitting resistance in inorganic and organic acids as well as resistance to inter-granular corrosion. This premium stainless steel electrode is ideal for welding molybdenum-enhanced stainless steels such as AISI 316, 316L, 317, and 317L. It can also be used on non-molybdenum bearing stainless steels such as AISI 301, 302, 304, 304L and 321.

## TECHNICAL DATA

Typical Values	
Tensile Strength:	85,000 psi (590 N/mm <sup>2</sup> )
Yield Strength:	69,000 psi (480 N/mm <sup>2</sup> )
Elongation:	40% at room temperature
Hardness:	220 BHN
Impact Strength (Charpy V):	40 ft - lbs at -150°F
Ferrite Content:	Magna Gauge Value between 4 - 10%
Current & Polarity:	AC or DCEP (+)

### SUGGESTED WELDING PARAMETERS:

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

*Note: When using StainTrode BMoL, keep to the low end of the amperage range for optimized results*

## PROCEDURE FOR USE

**PREPARATION:** Clean weld area of scale and/or oxide. Make sure all oily contaminants are removed with a suitable VOC-free cleaner. Angle prepping normally involves closebutts 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 2 times to 3 times weave beads. Do not weave more than three times the electrode diameter otherwise excessive heat input will cause distortion.

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

## TYPICAL APPLICATIONS

### APPLICATIONS

- Various Pump Parts
- Transport of Black/White Liquor
- Chemical Receivers

### INDUSTRY

- Petro-Chemical Industry
- Pulp & Paper
- Pharmaceutical Industry

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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