



## HI-ALLOY ST938

### GENERAL PURPOSE STAINLESS ELECTRODE

**DESCRIPTION:** Hi-Alloy ST938 is an exceptionally smooth running, spray transfer electrode that produces uniform spatter free welds. The unique dual flow coating greatly enhances welding speed, deposition and metal recovery rates. Deposits are highly ductile and crack resistant.

**TYPICAL APPLICATIONS:** Hi-Alloy ST938 was developed for use on most common grades of stainless steel. Typically used to fabricate and repair food, dairy and chemical equipment; particularly good for use on stainless grades 301, 302, 302B, 305, 308, 308L, 321, 347, and all AISI 200 and 400 types.

**PROCEDURES:** Clean and prepare weld zone in accordance with standard welding practice. **DO NOT PREHEAT.** Tack the parts to maintain alignment and reduce distortion. Maintain a short arc length or drag while tilting the electrode 15° in the direction of travel. Prevent excessive heat build up by skip welding whenever possible. Remove slag between passes and allow finished part to slow cool.

AVAILABLE SIZES:	3/32	1/8	5/32	3/16
AMPERAGE RANGES:	40-75	50-105	80-140	100-175
POLARITY:	AC or DC Reverse			
TENSILE STRENGTH:	Up to 88,000 psi			
YIELD STRENGTH:	Up to 66,000 psi			
ELONGATION:	Up to 45%			