



TEXAS * PENNSYLVANIA * NORTH CAROLINA
<http://hi-alloy.com>

HI-ALLOY

VERTICAL DOWN STAINLESS STEEL

SPECIAL ALLOY FOR VERTICAL WELDING

DESCRIPTION: Hi-Alloy Vertical Down Stainless Steel alloy possesses an exceptional fast freeze action which provides optimum control when welding stainless steels vertical up or vertical down. This alloy is ideal for the repair of stainless steels when poor fit up joints are encountered and for filling holes in stainless steel parts or castings.

TYPICAL APPLICATIONS: Fabrication or repair of products made of most common 300 series stainless steels, molybdenum bearing stainless steels, and thin stainless steels. Numerous uses include the medical, chemical, textile, paper, food, dairy, and distillery industries.

PROCEDURES: Clean the area to be welded in accordance with good welding practice, do not preheat, maintain a short arc length and whip the electrode quickly back and forth while moving up or down. When welding vertical set the amperage at the high end of the range and maintain a sharp angle with the electrode pointing upward.

AVAILABLE SIZES:	3/32	1/8
AMPERAGE RANGES:	60 - 80	90 - 110
POLARITY:	DC Reverse or AC	
TENSILE STRENGTH:	Up to 82,000 psi	
YIELD STRENGTH:	Up to 58,000 psi	
ELONGATION:	Up to 42%	