



HI-ALLOY 300A

CORROSION RESISTANT STAINLESS ALLOY

DESCRIPTION: Hi-Alloy 300A was designed to make smooth corrosion resistant weld deposits all on common austenitic stainless steels. Its low carbon content minimizes carbide precipitation along the grain boundaries of the deposit and the addition of molybdenum increases resistance to pitting and cavitations caused by sulphuric and phosphoric acid solutions. This product is commonly used in the welding of 302, 304, 308, and 316 stainless steels as well as their low carbon counterparts.

TYPICAL APPLICATIONS: Fabrication and repair of tanks, pipes, and fittings found in chemical plants, textile mills, and paper mills. It is also commonly used in the food, dairy, and distillery industries and is excellent as an overlay on standard steels when additional corrosion resistance is required.

PROCEDURES: Thoroughly clean the area to be welded of all contaminants. Parts 3/16" or thicker should be beveled and tacked to maintain alignment. A short to medium arc length should be maintained and the electrode tilted 15° in the direction of travel. Use stringer beads rather than a weave technique and prevent overheating the base metal. Remove slag between passes and allow the part to cool slowly in still air.

AVAILABLE SIZES:	3/32	1/8	5/32
AMPERAGE RANGES:	55-75	75-110	90-140
POLARITY:	AC or DC Reverse		
TENSILE STRENGTH:	Up to 85,000 psi		
YIELD STRENGTH:	Up to 60,000 psi		
ELONGATION:	Up to 40%		