



Overview

3881 Electrode is a maintenance alloy for welding on all common grades of 300 Series stainless steels, including the extra-low-carbon versions. Designed specifically to deposit sound X-ray quality welds in the vertical-down position.

Features/Benefits

- Excellent for use in all positions, especially vertical-down
- High molybdenum content to protect against pitting and corrosion
- Extra-low carbon to protect against carbide precipitation (sensitization)
- Easy slag removal
- Excellent restrike capability

Applications

- Piping
- Tanks
- Valves
- Thin sections
- Hospital equipment
- Food processing equipment

Method of Application

AC or DC reverse polarity

Identification

Printed gray coating on electrode

Directions for Use

Use AC or DC reverse polarity with normal maintenance welding procedures. Surface area should be clean and dry, but 3811 Electrode is manufactured with special cleansing and fluxing agents to promote sound welds under most conditions. For vertical-down welding, hold a short arc and tilt the electrode 10° in the direction of travel, using a stringer bead technique

Technical Specifications

Tensile Strength: 84,000 PSI (579 MPa)
Elongation: 40%

Technical Tips

Keep in dry storage, since this flux coating is susceptible to moisture absorption.

