



We are a NM Corporation  
Our NM CRS #02-183114-00-9  
Our Federal ID #85-0394484  
We are a NM Corporation

## QUADSTAIN™ L3600 VDH

### VERTICAL DOWNHAND STAINLESS STEEL

- USE AS TIG PROCESS SUBSTITUTE
- TENSILE STRENGTH (109,000 PSI)
- EXCELLENT DUCTILITY (42%)
- CONTROLLED LOW CARBON CONTENT
- SUPERIOR DOWN HAND
- SUPERIOR CORROSION RESISTANCE
- CRACK FREE
- EASY SLAG REMOVAL
- POROSITY FREE
- MULTI PASS
- REDUCES CARBIDE PRECIPITATION
- REDUCED ROOT GRINDING

### GENERAL CHARACTERISTICS:

Quadstain™ L3600 VDH represents a revolution in stainless steel welding. It is specially formulated for vertical down-hand welding. It is especially effective in pipe applications where a tig root pass is normally required. This is no longer necessary! Quadstain™ L3600 VDH employs a unique metal transfer system which allows for downhill application on stainless steels as thin as 22 gauge. Deposits are slag free, completely homogenous and fully radiographic. Tests with L3600 VDH versus standard tig/stick pipe applications on pipe prove a savings of up to 75% in application and labor time. Down time on repairing leaking pipes is reduced to a trickle due to L3600 VDH's unique ability to weld through water!

### PROCEDURES:

Ensure that all foreign material is removed form base metal. A 33° bevel should be maintained when welding schedule 10 or heavier pipe. Ensure that proper land is maintained in relation to pipe thickness. Do not preheat! Hold a medium short arc with electrode tilted 15° in the direction of travel. Flux red-out does not adversely affect performance.

### APPLICATIONS:

Quadstain™ L3600 VDH is indicated for all AISI 316, 316L, 321, and 347 type stainless steels. In addition, Quadstain™ L3600 VDH is also used to join these stainless types to carbon steel.

### TECHNICAL DATA:

HARDNESS.....18-20 RC  
CURRENT.....DC (REVERSE POLARITY)  
TENSILE STRENGTH .....109,000 PSI  
CORROSION RESISTANCE.....SUPERIOR

| ELECTRODE SIZE | AMPS   |
|----------------|--------|
| 1/16           | 25-40  |
| 5/64           | 40-55  |
| 3/32           | 60-80  |
| 1/8            | 90-110 |

MADE IN USA

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