

# PRODUCT DATA SHEET

## Stainshield®

Stainshield® is a general formulation gas for welders using the GMAW process on all stainless steels. It offers an economical solution, suitable for many applications on a wide range of metal thicknesses. Stainshield® is particularly suitable where minimal oxidation of the weld is required and where it is important to avoid risk of carbon contamination of the product. Stainshield® performs well across a range of applications providing good arc stability in dip, pulse and spray transfer modes.

Afrox MSDS number: SG/MSDS 5

### Hazards

- Asphyxiant in high concentrations
- Compressed – high pressure gas mixture in cylinders.

### Classifications

#### Gas Components

Argon

Oxygen

Material Description	Mass (kg)	Cylinder Capacity (ℓ)	Pressure @ 20°C (Bar)	Valve Outlet Connection	Item Number
STAINSHIELD® CYL 17,4 KG	17,4	50,0	200	5/8" BSPF right hand female	27-SE

### Applications

- All stainless steels
- Tubing and pipework
- Tanks and vessels.

Features	Benefits
High weld quality	Proven technology
Good penetration	Low porosity and other defects
No carbon pick-up	Maintains corrosion resistance
Low levels of nitrogen and moisture	Versatile – can be used across a range of thicknesses
High levels of accuracy and quality control during production	Low spatter
	Reproducible weld quality from cylinder to cylinder

### Precautions in Use

- Use only approved pressure rated equipment
- Use only in well ventilated areas
- Open cylinder valve slowly
- Close cylinder valve when not in use
- Do not allow oil or grease on cylinder or valve
- Cylinders should be secured from falling over
- Refer to MSDS for more information.

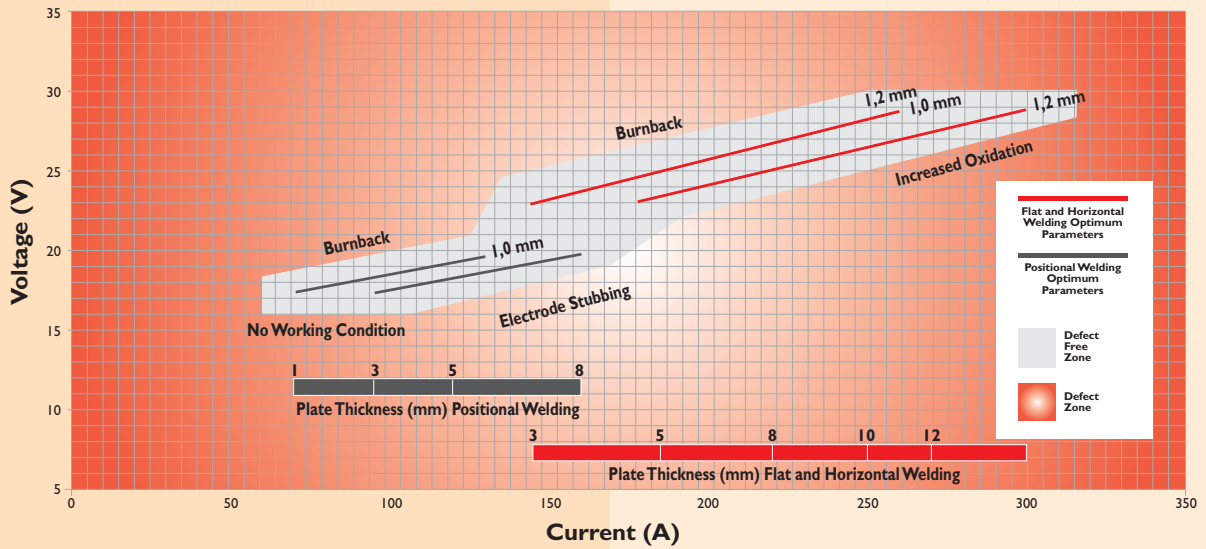
### Material Compatibility

Stainshield® is non-corrosive and so any common metal is acceptable, provided the equipment is designed to withstand process pressure.

### Current/Voltage Envelope

Operating limits for 1,0 mm and 1,2 mm diameter wires.

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Electrode stick out, contact tip-to-work distance 19-25 mm for spray, 8-13 mm for dip,  
gas flow rate 15-18 l/min

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