



SB-18-003

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Cleaning/Polishing Stainless Steel

The blued area on stainless should be sanded lightly with a 120 Grit sand paper disc, then a 600 Grit sand paper disc to remove scratches.

The weld should then be buffed with a sheepskin buffing pad on a drill motor, using Sherwin-Williams Buffing Compound, part number USC 40143

Stainless Steel Welding & Cleaning:

Welding of mild or carbon steel to stainless or stainless to stainless steel

Recommended material for wire welding: ER-309 (spec's listed below)

Recommended material for rod/stick welding: 309-15 & 309-16 (spec's listed below)

Welding Wire ER-309 – MIL-E-199330

Carbon:	0.025 max.	Tensile Strength:	80,000 psi
Manganese	1.80%	Elongation:	38%
Silicon:	0.40%		
Chromium:	24.00%		
Nickel:	13.50%		

Arc Welding Electrodes (Rods) – ASME-SFA 5.4.F-5, A-8 MIL-E-22200/2

Carbon:	0.07%	Tensile Strength:	90,000 psi
Manganese:	1.60%	Yield Strength:	70,000 psi
Silicon:	0.50%	Elongation in 2":	0.35%
Chromium:	24.00%		
Nickel:	12.50%		

Any other questions regarding this service bulletin should be directed to Utility's Field Service Department at 800-423-6591.

Field Service Department
UTILITY TRAILER MANUFACTURING COMPANY

Utility hasn't independently evaluated the information contained in the technical bulletin; it is making the bulletin available as a convenience and for information purposes. You are encouraged to contact the Field Service Dept at (800) 423-6591 if you have any questions concerning the content of the document, or how these issues affect trailers you are servicing.