



SUPERINOX 2D

CLASSIFICATIONS

AWS A/SFA 5.4 E 317L-16
 IS 5206 E 19.12.3 LR26

COATING TYPE: Rutile
 COATING FACTOR: Medium IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5
150-	110-	80-	50-
180	140	100	75

CHARACTERISTICS

An extra low Carbon, 19/13/Mo SS electrode with controlled Ferrite content of 4 to 9% for maximum resistance to cracking. The weld metal is of radiographic quality. Weld metal is resistant to Stress Corrosion cracking, Hot Cracking, Chemical corrosion at high temp. Higher Mo content reduces susceptibility of pitting. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

TYPICAL APPLICATIONS

For the welding of 19/13/Mo SS, represented by AISI types 316L/317; For welding of equipments on chemical industries (Especially for Sulphuric and Sulphurous acids and their salts), Paper and pulp industry, Paint and dye industries.

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	RA %	Ferrite No.
AW	550-620	30-40	50 min.	4-9

AW : As-welded

WELD METAL CHEMISTRY, wt%

C - 0.04 max.	S - 0.03 max.	Cr - 17.0-20.0
Mn - 1.0-2.5	P - 0.03 max.	Mo - 3.0-4.0
Si - 0.30-0.75	Ni - 11.0-14.0	

PACKING DATA

Dia., mm	4.0	3.2	2.5
Length, mm	300	300	300
Wt. per carton, kgs	6	6	6
Cartons/ box	3	3	3
Wt. per box, kgs	18	18	18