



SUPERINOX 2D

STAINLESS STEEL (Austenitic Steel)



Stainless steel Electrode for SCC and chemical resistance

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E 19 12 3 L R 12

E 317L-16

E 19.12.3 LR26

KEY FEATURES :

- Rutile based coating
- Extra low carbon 19/13/Mo SS deposit
- Resist intergranular corrosion and cracking
- Resistant to SCC, hot cracking and chemical attack upto 850°C
- Radiographic quality weld
- Offers improved resistance to pitting and crevice corrosion
- Improved high temperature creep strength than 316 type
- Excellent welding characteristics
- Easy slag detachability
- Suitable for all position welding

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding Mo bearing austenitic alloys represented by AISI 316, 316L, 317
- Welding of chemical vessels, steel tube, steel strip and casting
- Cladding stainless steels
- Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
Typical	0.03	1.5	0.5	19.0	12.7	3.4	0.02	0.02	-
Specification	0.04 max.	0.5-2.5	1 max	18.0-21.0	12.0-14.0	3.0-4.0	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	590	36	6
Specification		520	30 min	4-9

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	50-75	2	5	10
3.15 x 350	80-100	2	5	10
4.0 x 350	110-140	2	5	10