



SUPERINOX 1AH

STAINLESS STEEL (Austenitic Steel)



18/8 type stainless steel Electrode with improved strength and creep resistance

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

APPROVALS :

E 19 9 R 12

E 308H-16

IRS

KEY FEATURES :

- Rutile coated electrode
- 19/10 type austenitic SS weld
- Enhanced carbon content provide improved tensile strength and creep resistance at elevated temperatures
- Controlled ferrite content for maximum cracking resistance
- Radiographic quality weld
- Suitable for all position except vertical down

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of AISI 304, 304H, 321H, 347H stainless steels
- Suitable for material no. 1.4301, 1.4948, 1.4878
- For petrochemical and nuclear industries for elevated temperature creep resistance application

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
Typical	0.07	19.5	10.2	-	1.5
Specification	0.04-0.08	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	Si	P	S	Cu	
Typical	0.6	0.02	0.02	-	
Specification	1 max	0.04 max	0.03 max	0.75 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	605	37	4
Specification		550 min.	30 min.	3-7

Hardness, 3 layer: 220 BHN max

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