# SUPERINOX 1B

## AWS A/SFA 5.4 E347-16

**STAINLESS STEEL (Austenitic Steel)**

**CLASSIFICATION:**

**ISO 3581-A**
E 19 9 Nb R 12

**IS 5206**
E 19.9 Nb R26

**KEY FEATURES:**

- Rutile based coating
- Resistance to cracking and embrittlement
- Resistance to intergranular corrosion and scaling upto 850°C
- 19/10/Nb stabilized weld deposit
- Smooth operating characteristics
- All position capability
- Radiographic quality weld

**APPROVALS:** BV/IRS/IBR/CE

**TYPICAL APPLICATIONS:**

- Fabrication of equipments in refineries, power plants, centrifugal pump impellers and shafts, valve faces, seats
- Suitable for material no. 1.4300, 1.4301, 1.4306, 1.4308, 1.4310, 1.4541, 1.4543, 1.4550, 1.4552, 1.4878, 1.6905
- Fabrication of boiler and gas turbine paper and pulp, paint and dye industries
- Welding of stainless steel tanks, valves, pipes in food, chemical and petrochemical industries
- Welding stabilized Cr-Ni steels such as AISI 321, 321H, 347, 347H

**TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:**

| C | Mn | Si | Cr | Ni | Nb |
|---|---|---|---|---|---|
| 0.035 | 1.1 | 0.75 | 20.7 | 9.9 | 0.6 |

**MECHANICAL PROPERTIES OF ALL WELD METAL:**

| | Condition | UTS, MPa | EL% | Ferrite No. |
|---|---|---|---|---|
| Typical | As Welded | 600 | 35 | 7 |
| Specification | | 520 min | 30 min | 3-9 |

**Special Tests**: IGC Practice E of ASTM A262

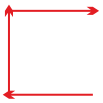
**PARAMETERS - PACKING DATA:**

| Ø x L, mm | Amperage, A |
|---|---|
| 2.0 x 300 | 35-45 |
| 2.5 x 350 | 50-75 |
| 3.15 x 350 | 80-100 |
| 4.0 x 350 | 110-140 |
| 5.0 x 300 | 150-180 |

**AC (70 OCV) /DCEP**

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

All Positions, except vertical Downwards



Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.

**EQUIVALENT:**

| GMAW | GTAW | FCAW | SAW | |
|---|---|---|---|---|
| | | | Flux | Wire |
| Miginox 347 | Tiginox 347 | Miginox FC 347 | Automelt S33 | Subinox 347 |

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