



# SUPERINOX 1B

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E347-16**

### CLASSIFICATION:

ISO 3581-A  
E 19 9 Nb R 12

IS 5206  
E19.9 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	 <b>AC (70 OCV) /DCEP</b> All Positions, except vertical Down  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.
2.5 x 350	50-75	
3.15 x 350	80-100	
4.0 x 350	110-140	
5.0 x 300	150-180	

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

### EQUIVALENT:

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