



## SUPERINOX 1B

STAINLESS STEEL (Austenitic Steel)



Nb stabilized stainless steel Electrode for highest resistance against intergranular corrosion.

CLASSIFICATION : ISO 3581-A	AWS A/SFA 5.4	IS 5206	APPROVALS:
E 19 9 Nb R 12	E 347-16	E 19.9 Nb R26	IRS/NTPC

### 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

### WELDING POSITION :



AC (70 OCV)/DCEP

### 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
- 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

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

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.04	19.5	10.0	0.2	1.4
Specification	0.08 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	Si	P	S	Cu	Nb plus Ta
	0.5	0.02	0.01	-	0.5
Specification	1 max	0.04 max	0.03 max	0.75 max	8xC, min to 1.00 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	600	35	8
Specification		520	30 min	6-9

### PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	35-45	2	5	10
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
5.0 x 300	150-180	2	5	10

EQUIVALENT : GMAW wire: Miginox 347 GTAW filler: Tiginox 347 FCAW wire: Miginox FC 347