



## SUPERINOX 1C-15 LT

STAINLESS STEEL (Austenitic Steel)



19/10 type stainless steel Electrode for cryogenic application

**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

**IS 5206**

E 19 9L B 22

E 308L-15

E 19.9 LB20

### KEY FEATURES :

- Basic coated electrode
- Extra low carbon 19/10 type weld
- Resist inter-crystalline corrosion
- Exhibit excellent toughness properties at subzero temperatures
- Controlled ferrite content of 0 to 2 for cryogenic applications
- Excellent corrosion and scaling resistance at high temperatures
- Radiographic quality weld deposit

### WELDING POSITION :



**DCEP**

### TYPICAL APPLICATIONS :

- For cryogenic applications of AISI 302, 304, 304L steels
- Dairy industry, chemical and fibre industry
- Welding of 18/8 type steels represented by AISI 301, 302, 304, 304L, 308, 308L

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

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

	<b>C</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Mn</b>
Specification	0.04 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	<b>Si</b>	<b>P</b>	<b>S</b>	<b>Cu</b>	
Specification	1 max	0.04 max	0.03 max	0.75 max	

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>	<b>CVN Impact at -196°C, J</b>	<b>Ferrite No.</b>
Typical	As Welded	580	37	52	3
Specification		520	30 min	30 min	7

**Typical Lateral Expansion : 0.50 mm**

**SPECIAL TEST : IGC Practice E of ASTM A262**

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
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