



SUPERINOX 1C-15 LT

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 E308L-15

CLASSIFICATION:

ISO 3581-A
E 19 9L B 22

IS 5206
E19.9 LB20

APPROVALS: ABS/CE

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

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

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

| C | Mn | Si | Cr | Ni |
|-------|-----|-----|------|------|
| 0.025 | 0.9 | 0.4 | 19.5 | 10.4 |


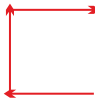
MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | EL% | CVN Impact at -196°C, J | Ferrite No. |
|---------------|-----------|----------|--------|-------------------------|-------------|
| Typical | As Welded | 580 | 37 | 52 | 2 |
| Specification | | 520 min | 30 min | 30 min | 5 max |

Special Tests: IGC Practice E of ASTM A262

Typical lateral expansion: 0.50 mm at -196°C

PARAMETERS - PACKING DATA:

| Ø x L, mm | Amperage, A | | |
|------------|-------------|--|--|
| 2.5 x 350 | 50-75 |  DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr. | All Positions, except vertical Down  |
| 3.15 x 350 | 80-100 | | |
| 4.0 x 350 | 110-140 | | |

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

EQUIVALENT:

| GTAW | SAW | |
|------------------|--------------|------------------|
| | Flux | Wire |
| Tiginox 308L SPL | Automelt S33 | Subinox 308L SPL |