



SUPERINOX 2A

STAINLESS STEEL (Austenitic Steel)



Stainless steel Electrode for chemical-pitting resistance

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

APPROVALS:

E 19 12 2 R 12

E 316-16

E 19.12.2 R26

RDSO

KEY FEATURES :

- Rutile type coating
- 19/12/Mo SS electrode
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Controlled ferrite content for maximum cracking resistance
- Excellent welder appeal
- All position capability
- Radiographic quality weld

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding Mo bearing austenitic alloys represented by AISI 316, 317
- Suitable for material no. 1.4401 & similar grades
- Welding of equipments in Chemical, Paper and pulp, Paint and dye industries

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.04	19.0	12.0	2.4	1.5
Specification	0.04 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	Si	P	S	Cu	
	0.02	0.02	0.02	-	
Specification	1 max	0.04 max	0.03 max	0.75 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	595	36	6
Specification		520	30 min	4-8

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