



SUPERINOX 2A

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E316-16**

CLASSIFICATION:

ISO 3581-A
E 19 12 2 R 12

IS 5206
E19.12.2 R26

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

APPROVALS: RDSO/IBR/CE

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


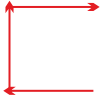
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.03	1.0	0.4	18.5	11.2	2.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	595	36	4
Specification		520 min	30 min	3-8

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 AC (70 OCV) /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		
5.0 x 350	150-180		

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