



SUPERINOX 2B

STAINLESS STEEL (Austenitic Steel)



A stabilized 19/12/2Mo type stainless steel electrode for resistance to variety of conventional and organic acids

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

E 19 12 3 Nb R 12

E 318-16

KEY FEATURES :

- Rutile type coating
- 19/12/2Mo/Nb type weld deposit
- Resistant to sulphuric acid and organic acids at operating temperature upto 400°C
- Radiographic quality weld
- Shows good cracking resistance
- Smooth arc and least spatter
- Easily controlled slag
- Excellent bead appearance

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding unstabilized and stabilized austenitic SS of AISI 318, 316, 316Ti
- Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4550, 1.4552, 1.4571, 1.4580
- Welding of chemical vessels and pipelines
- Suitable as buffer layer on unalloyed steels before joining to austenitic grades

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.04	18.7	12.4	2.5	1.4
Specification	0.08 max	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5
	Si	P	S	Cu	Nb plus Ta
	0.5	0.02	0.02	-	0.4
Specification	1 max	0.04 max	0.03 max	0.75 max	6xC, min to 1.00 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	590	35	6
Specification		550	25 min	3-8

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