



SUPERINOX 2B

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E318-16**

CLASSIFICATION:

ISO 3581-A
E (19 12 3 Nb) R 12

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

APPROVALS: CE

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


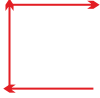
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Nb	Mo
0.035	1.0	0.8	18.7	11.9	0.4	2.0

MECHANICAL PROPERTIES OF ALL WELD METAL:

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

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