



## SUPERINOX 1A

STAINLESS STEEL (Austenitic Steel)



Stainless steel electrode for joining 18/8 type stainless steels

CLASSIFICATION : ISO 3581-A	AWS A/SFA 5.4	IS 5206	APPROVALS:
E 19 9 R 12	E 308-16	E 19.9 R26	RDSO/NTPC

### KEY FEATURES :

- Rutile based coating
- 19/10 type austenitic SS weld
- Resistant to cracking, corrosion and scaling upto 800°C
- Controlled ferrite content
- Smooth operating characteristics
- All position capability
- Radiographic weld quality

### WELDING POSITION :



AC (70 OCV)/DCEP

### TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304 and 308
- Fabrication of boilers, reactors and turbines
- Suitable for material no. 1.4300, 1.4301, 1.4310, 1.4312, 1.4550, 1.4001, 1.4016, 1.4057
- Build up application on SS surfaces of centrifugal pump impellers and shafts valve faces, seats etc.
- SS piping in refineries, oil & gas industries, chemical plants

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

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
Typical	0.05	19.0	10.2	-	1.2
Specification	0.08 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	Si	P	S	Cu	
Typical	0.6	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	600	40	5
Specification		550	30 min	3-7

### 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
5.0 x 300	150-180	2	5	10