



SUPERINOX 1A-15

STAINLESS STEEL (Austenitic Steel)



Basic type Electrode for 18/8 type stainless steels

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E 19 9 B 22

E 308-15

E 19.9 B20

KEY FEATURES :

- Basic type coating
- 19/10 type austenitic SS weld
- Resistant to cracking, corrosion and scaling upto 800°C
- Controlled ferrite content
- Radiographic weld quality
- All position capability
- Excellent welder appeal

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Welding Cr-Ni steels of AISI 301, 302, 304 and 308 types
- Build up application on SS surfaces of centrifugal pump impellers and shafts valve faces, seats etc.
- For steels of difficult weldability such as certain armour steel grades
- Suitable for material no. 1.4300, 1.4301, 1.4310, 1.4312, 1.4550, 1.4001, 1.4016, 1.4057

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
Specification	0.08 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	Si	P	S	Cu	
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	610	37	6
Specification		550 min	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	50-70	2	5	10
2.5 x 350	80-100	2	5	10
3.15 x 350	110-140	2	5	10
4.0 x 350	150-180	2	5	10