



SUPERINOX 1C

STAINLESS STEEL (Austenitic Steel)



19/10 type extra low carbon stainless steel Electrode

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

APPROVALS:

E 19 9 L R 12

E 308L-16

E 19.9 LR26

NPCIL/IRS/MND

KEY FEATURES :

- Extra low carbon 19/10 type austenitic weld
- Excellent corrosion and scaling resistance upto 800°C
- Controlled ferrite content for maximum cracking resistance
- Rutile based coating
- Suitable for all position welding
- Radiographic quality weld deposit

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308, 308L
- Fabrication of boilers, reactors and turbines
- Build up application on SS
- SS piping in refineries, oil and gas Industries, chemical plants
- 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	0.04 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	590	37	5
Specification		520	30 min	3-7

Hardness, 3 Layer: 150-200 BHN

SPECIAL TEST: IGC Test as per ASTM A262 Practice E, CVN Impact Test at subzero temperature

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

EQUIVALENT: GMAW wire: Miginox 308L GTAW filler: Tiginox 308L FCAW wire: Miginox FC 308L