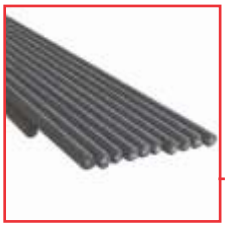
ador
peace of mind™



SUPERINOX 2C

STAINLESS STEEL (Austenitic Steel)

Stainless steel Electrode for high pitting resistance

CLASSIFICATION : ISO 3581-A	AWS A/SFA 5.4	IS 5206	APPROVALS:
E 19 12 3 L R 12	E 316L-16	E 19.12.2 LR26	NPCIL/IRS

KEY FEATURES :

- Rutile type coating
- Extra low carbon 19/13/Mo type weld
- High resistance against intergranular corrosion
- Resistant to SCC, hot cracking & chemical attack upto 850°C
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Suitable for all position
- Radiographic quality weld

WELDING POSITION : 

AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding Mo bearing austenitic alloys represented by AISI 316, 316L, 317, 317L, 318 types
- Welding of equipments in textile processing, Naval and Chemical environments, Paper and pulp, Paint and dye industries
- Joining similar grade wrought and cast material
- Cladding stainless steels
- Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
Typical	0.04	1.2	0.5	18.7	12.8	2.5	0.02	0.02	-
Specification	0.04 max.	0.5-2.5	1 max	18.0-21.0	9.0-11.0	0.75 max	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	565	35	6
Specification		490	30 min	3-8

SPECIAL TEST : IGC practice E as per ASTM A262

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 316L GTAW filler: Tiginox 316L FCAW wire: Miginox FC 316L