

# SUPERINOX 2D

AWS A/SFA 5.4 E317L-16

STAINLESS STEEL (Austenitic Steel)

## CLASSIFICATION:

ISO 3581-B  
ES 317L- 16

IS 5206  
E 19.12.3 LR26

## KEY FEATURES:

- Rutile based coating
- Extra low carbon 19/13/Mo SS deposit
- Resist intergranular corrosion and cracking
- Resistant to SCC, hot cracking and chemical attack upto 850°C
- Offers improved resistance to pitting and crevice corrosion
- Improved high temperature creep strength than 316 type
- Excellent welding characteristics
- Easy slag detachability
- Suitable for all position welding
- Radiographic quality weld

**APPROVALS:** IBR/CE

## TYPICAL APPLICATIONS:

- Welding Mo bearing austenitic alloys represented by AISI 316, 316L, 317
- Welding of chemical vessels, steel tube, steel strip and casting
- 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



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

C	Mn	Si	Cr	Ni	Mo
0.03	0.85	0.7	19.0	12.1	3.35

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	590	36	6
Specification		520 min	30 min	4-9

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 50-75 80-100 110-140	 <b>AC (70 OCV) /DCEP</b> <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.