



SUPERINOX 1A

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E308-16**

CLASSIFICATION:

ISO 3581-A
E 19 9 R 12

IS 5206
E 19.9 R26

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

APPROVALS: LRA/RDSO/IBR/CE

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


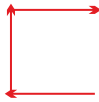
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.04	1.0	0.5	20.1	9.7

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	600	40	5
Specification		550 min	30 min	3-8

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.0 x 300	35-45	 AC (70 OCV) / DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
2.5 x 350	50-75	
3.15 x 350	80-100	
4.0 x 350	110-140	
5.0 x 350	150-180	

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.