



SUPERINOX 1AH

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E308H-16**

CLASSIFICATION:

ISO 3581-A
E 19 9 R 12

IS 5206
E19.9R36

KEY FEATURES:

- Rutile coated electrode
- 19/10 type austenitic SS weld
- Enhanced carbon content provide improved tensile strength and creep resistance at elevated temperatures
- Controlled ferrite content for maximum cracking resistance
- Radiographic quality weld
- Suitable for all position except vertical down

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of AISI 304, 304H, 321H, 347H stainless steels
- Suitable for material no. 1.4301, 1.4948, 1.4878
- For petrochemical and nuclear industries for elevated temperature creep resistance application


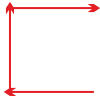
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.07	1.0	0.7	20.6	9.7

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	605	37	4
Specification		550 min	30 min	3-8

PARAMETERS - PACKING DATA:

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

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