



SUPERINOX 2C

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E316L-16**

CLASSIFICATION:

ISO 3581-A
E (19 12 3 L) R 12

IS 5206
E19.12.2 LR26

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

APPROVALS: BV/IRS/NPCIL/IBR/CE

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

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:



C	Mn	Si	Cr	Ni	Mo
0.03	0.85	0.4	18.5	11.2	2.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	565	35	4
Specification		490 min	30 min	3-8

Special Tests: IGC Practice E/C of ASTM A262

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	

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

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 316L	Tiginox 316L	Miginox FC 316L	Automelt S33	Subinox 316L