



SUPERINOX 2D

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E317L-16**

CLASSIFICATION:

ISO 3581-B
ES 317L- 16

IS 5206
E19.12.3 LR26

APPROVALS: IBR/CE

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

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	3-9

PARAMETERS - PACKING DATA:

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

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