



# Superinox 1A

STAINLESS STEEL (Austenitic Steel)

Stainless steel electrode for joining 18/8 type stainless steels

CLASSIFICATION :	EN 1600	AWS A/SFA 5.4	IS 5206	APPROVALS:
	E 19 9 R 12	E 308-16	E 19.9 R26	RDSO/NTPC

**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

WELDING POSITION :		AC (70 OCV)/DCEP
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**TYPICAL APPLICATIONS :**

- Welding Cr-Ni steels represented by AISI 301, 302, 304 and 308
- Fabrication of boilers, reactors and turbines
- SS piping in refineries, oil and gas industries, chemical plants
- Build up application on SS surfaces of centrifugal pump impellers and shafts valve faces, seats etc.
- Suitable for material no. 1.4300, 1.4301, 1.4310, 1.4312, 1.4550, 1.4001, 1.4016, 1.4057

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

**CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :**

	C	Mn	Si	Cr	Ni	S	P
Typical	0.05	1.2	0.6	19.0	10.2	0.02	0.02
Specification	0.08 max	0.70-2.0	0.30-0.85	18.0-21.0	9.0-11.0	0.03 max	0.04 max

**MECHANICAL PROPERTIES OF ALL WELD METAL :**

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	600	40	5
Specification		560-660	35-50	3-7

**PARAMETERS - PACKING DATA :**

Ø x L , mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	35-45	2	5	10
2.5 x 300	50-75	2	5	10
3.15 x 300	80-100	2	5	10
4.0 x 300	110-140	2	5	10
5.0 x 300	150-180	2	5	10