



# Superinox 1AH

STAINLESS STEEL (Austenitic Steel)

18/8 type stainless steel Electrode with improved strength and creep resistance

CLASSIFICATION : EN 1600      AWS A/SFA 5.4      APPROVALS :  
    E 19 9 R 12      E 308H-16      IRS

**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

WELDING POSITION :



AC (70 OCV)/DCEP

**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

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	0.07	1.5	0.6	19.5	10.2	0.02	0.02
Specification	0.04-0.08	0.70-2.50	0.30-0.80	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	605	37	4
Specification		550 min.	35 min.	3-7

Hardness, 3 layer: 220 BHN max

**PARAMETERS - PACKING DATA :**

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
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