Superinox 1C

STAINLESS STEEL (Austenitic Steel)

19/10 type extra low carbon stainless steel Electrode

CLASSIFICATION :	EN 1600	AWS A/SFA 5.4	IS 5206	APPROVALS:
	E 19 9 L R 12	E 308L-16	E 19.9 LR26	NPCIL/IRS/MND

KEY FEATURES :

- Rutile based coating
- Extra low carbon 19/10 type austenitic weld
- Excellent corrosion and scaling resistance upto 800°C
- Controlled ferrite content for maximum cracking resistance
- Suitable for all position welding
- Radiographic quality weld deposit

WELDING POSITION : 

AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308, 308L
- Fabrication of boilers, reactors and turbines
- Build up application on SS
- SS piping in refineries, oil and gas Industries, chemical plants
- 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	0.03	1.2	0.5	19.5	10.0	0.02	0.02
Specification	0.04 max.	0.60-2.0	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	590	37	5
Specification		530-650	35-40	3-7

Hardness, 3 Layer: 150-200 BHN

SPECIAL TEST : IGC Test as per ASTM A262 Practice E, CVN Impact Test at subzero temperature

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

EQUIVALENT : GMAW wire:Miginox 308L GTAW filler:Tiginox 308L FCAW wire:Miginox FC 308L