

SUPERINOX 1A

CLASSIFICATIONS

AWS A/SFA 5.4 E308-16
IS 5206 E 19.9 R26

APPROVALS

DCEL E 308-16 **RDSO** Cl. M1 **TOYO** E 308-16
KPG E 308-16 **BHEL** E 308-16 **NTPC**

IDENTIFICATION: Name Printed

CHARACTERISTICS

A 19/10 SS electrode with controlled Ferrite content of 3 to 7% for maximum resistance to cracking, corrosion and high temperatures up to 800°C. The weld metal has excellent creep strength and is of radiographic quality. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5	2.0
150-180	110-140	80-100	50-75	35-45

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1hour
 (Optionally also available in vacuum-packed condition.)

TYPICAL APPLICATIONS

For the welding of 18/8 SS, represented by AISI types 301, 302, 304 and 308; and German steel Nos. 4016, 4501, 4300, 4301 or continental steel V2A, Ugine NS 22S NS 21S, Avesta 832 MV; Soderfors 553, Sandvik OR-2; UHB Stainless 3 etc. Dump impellers, Steels of difficult weldability such as certain grades steel, for building-up stainless surfaces on centrifugal pump impellers and shafts, valve faces, seats and chemical plants.

WELD METAL CHEMISTRY, (%)

C - 0.08 max.	S - 0.03 max.	Cr - 18.0-21.0
Mn - 0.70-2.0	P - 0.04 max.	
Si - 0.30-0.85	Ni - 9-11	

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5	2.0
Length, mm	300	300	300	300	300
Wt. per carton, kg	2	2	2	2	2
Cartons / box	5	5	5	5	5
Net wt per box, kg	10	10	10	10	10

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
As-welded	560-660	35-50	3-7



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