

SUPERINOX 1B

CLASSIFICATIONS

AWS A/SFA 5.4 E347-16
IS 5206 E 19.9 Nb R26

IDENTIFICATION: Name Printed

CHARACTERISTICS

A 19/10Nb stabilized SS electrode with controlled Ferrite content of 6 to 9% for maximum resistance to cracking. Nb prevents Chromium Carbide precipitation in the temperature range of 425-823°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.

TYPICAL APPLICATIONS

For the welding of 18/8Nb stabilized SS, represented by AISI types 321, 347. Fabrication of equipments in Refineries, Chemical industries, Power plants, Centrifugal pump impellers and shafts, valve faces, seats.

WELD METAL CHEMISTRY, (%)

C - 0.08 max. S - 0.03 max Cr - 18.0-21.0
 Mn - 1.00-2.0 P - 0.04 max Nb - 8xC min to 1.0 max
 Si - 0.9 max. Ni - 9.0-11.0 Mo - 0.75 max

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
As-welded	550-690	30-40	6-9

APPROVALS

BHEL E 347-16 **NTPC**
Toyo E 347-16

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.)

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

SPECIAL TESTS

TEST TYPE	REMARKS
HIC & SSCC (NACE)	Passed



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