

# SUPERINOX 1C

## CLASSIFICATIONS

**AWS A/SFA 5.4** E308L-16  
**IS 5206** E 19.9 LR26

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

An extra-low Carbon 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.

## TYPICAL APPLICATIONS

For the welding of 18/8 SS, represented by AISI types 301, 302, 304 and 308 having low Carbon content.

### WELD METAL CHEMISTRY, (%)

C - 0.04 max. S - 0.03 max. Cr - 18.0-21.0  
Mn - 0.60-2.0 P - 0.04 max.  
Si - 0.30-0.85 Ni - 9.0-11.0

### MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4d)	Ferrite No.
As-welded	530-650	35-40	3-7

## APPROVALS

**DCEL** E 308L-16 **Toyo** E 308L-16  
**KPG** E 308L-16 **BHEL** E 308L-16  
**NPCIL** E 308L-16

**CURRENT CONDITIONS:** AC, DC (+)

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

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C for 1 hour  
(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

### PACKING DATA

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



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