

SUPERINOX 2A

CLASSIFICATIONS

AWS A/SFA 5.4 E316-16
IS 5206 E 19.12.2 R26

IDENTIFICATION: Name Printed

CHARACTERISTICS

A 19/12 Mo SS electrode with controlled Ferrite content of 4 to 8% for maximum resistance to cracking. The weld metal is of radiographic quality. Weld metal is resistant to Sulphuric, Hydrochloric, Acetic, Phosphoric, Citric, Tartaric acid, etc. 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 19/12 Mo SS, represented by AISI types 316, 317;
For welding of equipments on chemical industries, Paper and pulp industry, Paint and dye industries.

WELD METAL CHEMISTRY, (%)

C - 0.08 max.	S - 0.03 max.	Cr - 17.0-20.0
Mn - 1.0-2.5	P - 0.04 max.	Mo - 2.0-3.0
Si - 0.3-0.9	Ni - 11.0-14.0	

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
As-welded	530-650	30-40	4-8

APPROVALS

DCEL E 316-16
KPG E 316-16

RDSO Cl. M3
Toyo E 316-16

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.)

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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