

# SUPERINOX 2B

## CLASSIFICATIONS

**AWS A/SFA 5.4** E318-16

## CURRENT CONDITIONS: AC, DC (+)

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

**IDENTIFICATION:** Name Printed

## CHARACTERISTICS

19/12/2Mo stabilized SS electrode for maximum resistant 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.

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

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

## TYPICAL APPLICATIONS

For the welding of 19/12 Mo stabilized SS, represented by AISI types 18; 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 - 0.30-0.90	Ni - 11.0-14.0	Nb - 6xC to 1.0% max.

### 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

### MECHANICAL PROPERTIES- ALL-WELD

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



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