

SUPERINOX 2C

CLASSIFICATIONS

AWS A/SFA 5.4 E316L-16
IS 5206 E 19.12.2 LR26

IDENTIFICATION: Name Printed

CHARACTERISTICS

An extra low Carbon, 18/13/Mo SS electrode with controlled Ferrite content of 3 to 8% for maximum resistance to cracking. The weld metal is of radiographic quality. Weld metal is resistant to Stress Corrosion cracking, Hot Cracking, Chemical corrosion at high temp. upto 850°C. 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 18/13/Mo SS, represented by AISI types 316/316L/317; For welding of equipments on chemical industries, Paper and pulp industry, Paint and dye industries.

WELD METAL CHEMISTRY, (%)

C - 0.04 max.	S - 0.03 max.	Cr - 17.0-20.0
Mn - 0.7-2.0	P - 0.04 max.	Mo - 2.0-3.0
Si - 0.30-0.75	Ni - 11.0-14.0	

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
As-welded	510-610	30-40	3-8

APPROVALS

KPG E 316L-16
NPCIL E 316L-16 **TOYO** E 316L-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 1hour
(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

SPECIAL TESTS

* Meets IGC practice E as per ASTM A262



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