

SUPERINOX 2D

CLASSIFICATIONS

AWS A/SFA 5.4 E317L-16
IS 5206 E 19.12.3 LR26

CURRENT CONDITIONS: AC, DC (+)

4.0	3.2	2.5
110-140	80-100	50-75

IDENTIFICATION: Name Printed

WELDING POSITIONS

F, H, V-up, OH

CHARACTERISTICS

An extra low Carbon, 19/13/3Mo SS electrode with controlled Ferrite content of 4 to 9% 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. Higher Mo content reduces susceptibility of pitting. 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.

REDRYING CONDITIONS

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

TYPICAL APPLICATIONS

For the welding of 19/13/Mo SS, represented by AISI types 316L/317; For welding of equipments on chemical industries (Especially for Sulphuric and Sulphurous acids and their salts), Paper and pulp industry, Paint and dye industries.

WELD METAL CHEMISTRY, (%)

C - 0.04 max.	S - 0.03 max.	Cr - 18.0-21.0
Mn - 1.0-2.5	P - 0.04 max.	Mo - 3.0-4.0
Si - 0.30-0.75	Ni - 12.0-14.0	

PACKING DATA

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

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
As-welded	550-620	30-40	4-9



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