



Stainless steel Electrode for high pitting resistance

CLASSIFICATION :	EN 1600	AWS A/SFA 5.4	IS 5206	APPROVALS:
	E 19 12 3 L R 12	E 316L-16	E 19.12.2 LR26	NPCIL/IRS

KEY FEATURES :

- Rutile type coating
- Extra low carbon 19/13/Mo type weld
- High resistance against intergranular corrosion
- Resistant to SCC, hot cracking and chemical attack upto 850°C
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Suitable for all position
- Radiographic quality weld

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding Mo bearing austenitic alloys represented by AISI 316, 316L, 317, 317L, 318 types
- Welding of equipments in textile processing, Naval and Chemical environments, Paper and pulp, Paint and dye industries
- Joining similar grade wrought and cast material
- Cladding stainless steels
Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P
Typical	0.03	1.1	0.5	18.7	12.8	2.5	0.02	0.02
Specification	0.04 max.	0.7-2.0	0.3-0.75	17.0-20.0	11.0-14.0	2.0-3.0	0.03 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	565	35	6
Specification		510-610	30-40	3-8

SPECIAL TEST : IGC practice E as per ASTM A262

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	35-45	2	5	10
2.5 x 300	50-75	2	5	10
3.15 x 300	80-100	2	5	10
4.0 x 300	110-140	2	5	10

EQUIVALENT : GMAW wire:Miginox 316L GTAW filler:Tiginox 316L FCAW wire:Miginox FC 316L