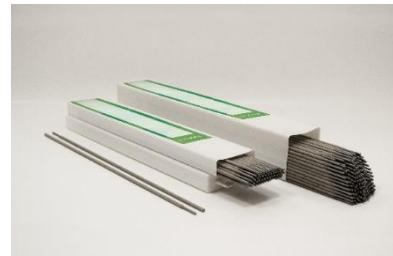


STAINLESS STEEL RUTILE ELECTRODE

#item	MDM	EAN	Dimensions
853724	9248903	3660338097485	2.5 x 350 / 47 units
853722	9249457	3660338097461	2.5 x 350 / 138 units
853725	9248880	3660338097492	3.2 x 350 / 28 units
853723	9249125	3660338097478	3.2 x 350 / 85 units



Description

Low carbon Rutile-basic-coated Mo containing austenitic stainless steel electrode with approx. 8% ferrite. Coating with very low moisture pick-up. Soft fusion without spatters, very easy slag removal, exceptional bead appearance, easy restriking. For welding and cladding on austenitic Cr-Ni-Mo stainless steels and clad plates.

Applications

Applied for service temperatures from -120°C up to +400°C in the chemical and petrochemical industries, in refineries, in the food industries and for ship building to weld pipes, tanks, heat exchangers.

Base materials, Stainless steels for general use:

UNS	Alloy	EN 10088	N° de Mat.	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo 19 11 2	1.44.8	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31650	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb 19-11-2	1.4581	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fr
<0,03	0,8	0,7	18,5	12,00	2,7	Base

All Weld Metal Mechanical Properties

R _{p0.2} (Mpa)	R _m (Mpa)	A ₅ (%)	KV (J)
>400	>560	>35	+20°C 70 -120°C 40

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x350	3,2x350
Current	(A)	70	100

Redrying at 250°C during 1h, if necessary. Interpass temperature : < 200°C.

Classification

AWS A5.4 : E316L-16

EN 1600 : E 19 12 3 L R 3 2

ISO 3581-A : E 19 12 3 L R 3 2