



# SUPERINOX 1C

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E308L-16**

### CLASSIFICATION:

ISO 3581-A  
E 19 9 L R 12

IS 5206  
E19.9 LR26

### KEY FEATURES:

- Extra low carbon 19/10 type austenitic weld
- Excellent corrosion and scaling resistance upto 800°C
- Rutile based coating
- Suitable for all position welding
- Radiographic quality weld deposit
- Controlled ferrite content for maximum cracking resistance

**APPROVALS:** ABS/BV/IRS/NPCIL/IBR/CE

### TYPICAL APPLICATIONS:

- Welding Cr-Ni steels represented by AISI 301, 302, 304, 304L, 308, 308L
- Fabrication of boilers, reactors and turbines
- Build up application on SS
- SS piping in refineries, oil and gas Industries, chemical plants
- Suitable for material no. 1.4300, 1.4301, 1.4310, 1.4312, 1.4550, 1.4001, 1.4016, 1.4057

### TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:


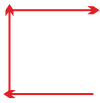
C	Mn	Si	Cr	Ni
0.03	0.9	0.4	19.6	9.1

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	590	37	5
Specification		520 min	30 min	3-8

**Special Tests:** IGC Practice E/C of ASTM A262

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	35-45	 <b>AC (70 OCV) /DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down  
2.5 x 350	50-75		
3.15 x 350	80-100		
4.0 x 350	110-140		

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.

### EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 308L	Tiginox 308L	Miginox FC 308L	Automelt S33	Subinox 308L