

RUTOX - D

CODIFICATION:

AWS : SFA 5.4 E316L-16
IS : 5206 E19.12.2.LR16
EN ISO : 3581-A E 19 12 3 L R 3 2

CHARACTERISTICS AND APPLICATIONS:

Rutox-D is a stainless steel electrode depositing an extra low carbon 18Cr - 12Ni - 2.3Mo stainless steel weld metal. The weld metal has excellent resistance to intergranular corrosion even at elevated temperatures. Ideally suited for welding stainless steels of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	Mo	S	P
Percent :	0.035	1.75	0.45	18.5	12.5	2.6	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	Elongation
(MPa)	(L = 5d)%
535	38.0

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm)	:	5x350	4x350	3.15x350	2.5x350
Dia x Length					
Current Range	:	150-180	110-140	80-100	60-80
(Amps)					
Weight/Carton	:	2.5	2.5	2.5	2.5
(kgs)					

APPROVALS : BHEL, CE, CIB-MP, EIL, L&T Power, NPCIL, PDIL

PRECAUTIONS :

1. Use short arc and stringer bead to restrict heat input.
2. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.

NOTE : Batox-D conforming to AWS E316L-15 is also available.

AUTHORISED DISTRIBUTOR - SALES & SERVICE

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