



## RUTOX-A

**CODIFICATION :** AWS : SFA 5.4 E308-16  
IS : 5206 E19.9 R16

### CHARACTERISTICS AND APPLICATIONS :

Rutox-A is a stainless steel electrode yielding a weld metal of 19Cr - 10Ni. The weld metal displays good resistance to cracking, corrosion and scaling. Ideally suited for welding stainless steel materials of similar composition like AISI 301, 302, 304, 308, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	C	Mn	Si	Cr	Ni	S	P
Percent	0.05	1.40	0.40	19.5	9.50	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L= 4d)%
604	38

### CURRENT AND PACKING DATA : AC / DC(+)

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

**APPROVALS :** Adani Infra, BHEL, EIL, NPCIL, NTPC, PDIL

### PRECAUTIONS :

1. Use short arc, low current and minimum weaving.
2. Ensure the electrodes are dry. Electrodes should be redry at 250-300°C and cool to 50-60°C in the same oven before use.