

RUTOX-AH

CODIFICATION : AWS : SFA 5.4 E308H-16

CHARACTERISTICS AND APPLICATIONS :

A stainless steel electrode depositing 19Cr - 10Ni stainless steel weld metal with carbon in the range of 0.04 - 0.08. Weld metal possesses excellent crack resistance and displays good elevated temperature properties. Ideally suited for joining 18/8 stainless steels where the carbon content is in the range of 0.04-0.08 i.e. AISI 304H material.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Cr	Ni	S	P
Percent :	0.06	1.40	0.40	19.5	10.0	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L= 4d)%
614	38

CURRENT AND PACKING DATA: AC / DC(+)

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

PRECAUTIONS:

1. If necessary, redry the electrodes at 250-300°C for one hour.
2. Use short arc, stringer bead and low current.
3. Avoid build-up of heat during welding.