



RUTOX-B

CODIFICATION : AWS : SFA 5.4 E308L-16
IS : 5206 E19.9L R16

CHARACTERISTICS AND APPLICATIONS :

A semi-basic electrode producing an extra low carbon 19Cr - 10Ni weld metal which has excellent resistance to intergranular corrosion. The weld metal has higher resistance to cracking, oxidation and scaling at elevated temperatures. Ideally suited for welding of stainless steels of similar composition like AISI 304L, 308L and their equivalents for overlays, surfacing applications, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

| | | | | | | | |
|-----------|------|------|------|------|------|-------|-------|
| Element : | C | Mn | Si | Cr | Ni | S | P |
| Percent : | 0.03 | 1.40 | 0.40 | 19.8 | 10.0 | 0.020 | 0.020 |

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

| | |
|--------------|-------------------------|
| UTS (MPa) | Elongation (L = 4d)% |
| 564 | 40 |

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 : Adani Infra, BHEL, EIL, L&T Power, NPCIL, NTPC, PDIL

PRECAUTIONS :

1. Ensure the electrodes are dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.
2. Use short arc and low currents.

NOTE : Batox-B conforming to AWS E308L-15 is also available.