

## RUTOX-B (SPL)

**CODIFICATION :** AWS : SFA 5.4 E308L-16

### CHARACTERISTICS AND APPLICATIONS :

Rutox-B(SPL) is a rutile coated electrode yielding an extra low carbon (0.028% max) with ferrite (5-10 FN) in the weld metal. The weld metal has excellent resistance to intergranular corrosion even at elevated temperatures.

- Ideally suited for welding stainless steels of similar composition.
- Ideal for joining wrought and cast materials.
- Surfacing & overlay applications.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	S	P	Cr	Ni
Percent :	0.025	1.75	0.30	0.020	0.022	20.0	10.0

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L= 4d)%
535	38.0

**CORROSION PROPERTY :** Weld metal meets ASTM A262 Practice E

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

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

### PRECAUTIONS:

- 1 The electrodes should be dry. In case of moisture pick-up re-dry the electrodes at 250-300°C for one hour.
- 2 Use lowest size of electrode possible and low current.
- 3 Use short arc.