Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

RUTOX -D(SPL)

CODIFICATION: AWS : SFA 5.4 E316L-16

CHARACTERISTICS AND APPLICATIONS:

It is a rutile coated electrode yielding an extra low carbon (0.025% max) with ferrite (6 -12 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 in a number of industries like rayon, dye, paper, chemical, fertilizer, petrochemicals, etc.
- Surfacing & overlay applications.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	:	C	Mn	Si	S	P	Cr	Ni	Mo
Percent	:	0.021	1.75	0.30	0.020	0.022	19.0	12.0	2.4

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

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

CORROSIONPROPERTY : Weld metal meets ASTM A262 Practice E

CURRENT AND PACKING DATA: AC / DC(+)

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

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.