RUTOX-Mo

CODIFICATION :

AWS	:	SFA 5.4 E316-16
IS	:	5206 E19.12.2R16

CHARACTERISTICS AND APPLICATIONS :

Rutox-Mo is a stainless steel electrode depositing a weld metal containing 18Cr - 11Ni - 2.3Mo. The weld metal displays good crack resistance, excellent creep strength and resists scaling at elevated temperatures up to 850°C. The weld metal has excellent resistance to corrosion and pitting. Ideal for joining wrought and cast material of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Cr	Ni	Mo	S	P
Percent	:	0.05	1.25	0.45	18.8	12.0	2.3	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L= 4d)%
564	38.0

CURRENT AND PACKING DATA : AC / DC(+)

Size (mm) Dia x Length	:	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	:	150-180	110-140	80-100	60-80
Weight/Carton (kgs)	:	2.5	2.5	2.5	2.5

APPROVALS : Adani Infra, BHEL, CIB-MP, EIL, 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 low current, short arc length and avoid weaving of the electrodes.

NOTE : Batox-Mo conforming to **AWS E316-15** is also available.