

RUTOX - Mo(H)

CODIFICATION: AWS : SFA 5.4 E316H-16

CHARACTERISTICS AND APPLICATIONS:

- A stainless steel electrode depositing an 18Cr - 12Ni - 2.5Mo stainless steel weld metal with high carbon up to 0.08.
- Provides higher tensile and creep strengths at elevated temperatures.
- Good crack resistance and resistance to scaling up to 850°C
- Joining AISI 316H and its equivalent materials in a number of industries like rayon, dye, paper, chemical, fertilizer, petrochemicals, etc.
- Surfacing and overlay applications.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	S	P	Cr	Ni	Mo
Percent :	0.07	1.30	0.45	0.020	0.020	18.00	12.00	2.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d)%
590	36.0

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 Re-dry the electrodes at 250-300°C for one hour.
- 2 Use short arc, stringer beads, and low currents.