Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

SIA (RUTILE)

CODIFICATION :

AWS : SFA 5.4 E307-16 (Nearest)
IS : 5206 E18.8Mn-R-26X

CHARACTERISTICS AND APPLICATIONS :

SIA(Rutile) is an electrode depositing 18Cr-8Ni-5Mn weld metal. Ideally suited for joining and surfacing applications to enhance resistance to impact and abrasion. Ideally suited for joining austenitic manganese steel to carbon steel, low alloy steel, etc., and also for buffer layers on a variety of steels.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Cr	Ni
Percent	:	0.07	6.0	0.60	19.0	9.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL

UTS (MPa)	Elongation (L=4d)%	Hardness
614	35.0	200-220 BHN (As welded) 500 BHN (Work hardens under impact)

CURRENT AND PACKING DATA: AC / DC(+)

Size (mm) Dia x Length	:	5x350	4x350	3.15x350	2.5x350
Current Range (Amps)	:	190-240	140-190	90-130	60-100
Qty.(Pcs./Carton)	:	25	40	60	80

PRECAUTIONS:

1. Ensure the electrodes are dry. Moist electrodes should be redry at 200-250°C for one hour.
2. Use short arc and minimum heat input.