RUTOX-A(ST)

CODIFICATION :

AWS	:	SFA 5.4 E347-16
IS	:	5206 E19.9Nb R16

CHARACTERISTICS AND APPLICATIONS :

Rutox-A (St) is an electrode depositing 18Cr-10Ni-Nb stabilised weld metal, suitable for joining of stainless steels of similar composition. Ideal for welding of AISI 304, 304L, 321, 347 and their equivalents. The weld metal has excellent resistance to intergranular corrosion.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	:	C	Mn	Si	Cr	Ni	Nb	S	P
Percent	:	0.05	1.40	0.45	19.0	10.0	0.60	0.018	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L= 4d)%
594	34.0

CURRENT AND PACKING DATA : AC / DC(+)

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

APPROVALS : Adani Infra, BHEL, BV, CIB-MP, EIL, NPCIL, NTPC, PDIL

PRECAUTIONS :

1. Ensure the electrodes are dry. Redry the moist electrodes at 250-300°C for one hour.
2. Use short arc length and stringer bead to reduce heat input.

NOTE : **Batox-A (ST)** conforming to **AWS E347-15** is also available.