Estd. 1966
D&H sécheron
Complete Welding Support

50 YEARS 1968 - 2018

RUTOX-C

CODIFICATION :

AWS : SFA 5.4 E318-16
IS : 5206 E19.12.2 Nb R16

CHARACTERISTICS AND APPLICATIONS :

Rutox-C is a stainless steel electrode producing extra low carbon, niobium stabilised 18Cr - 12Ni - 2.3Mo weld metal. The extra low carbon content and the stabilization impart excellent corrosion resistance against intergranular corrosion. The weld metal possesses good resistance to pitting and improved creep strength. It is ideally suited for joining stainless steels of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	C	Mn	Si	S	P	Cr	Ni	Mo	Nb
Percent	0.03	1.50	0.42	0.018	0.020	18.5	12.0	2.3	0.50

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 4d)%
580	36.0

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

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 short arc, low current and lowest size of electrode possible.

NOTE: Batox-C conforming to **AWS E318L-15** is also available.