



## RUTOX -D

**CODIFICATION:** AWS : SFA 5.4 E316L-16  
IS : 5206 E19.12.2.LR16

### CHARACTERISTICS AND APPLICATIONS:

Rutox-D is a stainless steel electrode depositing an extra low carbon 18Cr - 12Ni - 2.3Mo stainless steel weld metal. The weld metal has excellent resistance to intergranular corrosion even at elevated temperatures. Ideally suited for welding stainless steels of similar composition.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	Mo	S	P
Percent :	0.035	1.75	0.45	18.5	12.5	2.3	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	Elongation
(MPa)	(L = 4d)%
535	38.0

### CURRENT AND PACKING DATA : AC / DC(+)

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

**APPROVALS :** BHEL, CIB-MP, EIL, L&T Power, NPCIL, PDIL

### PRECAUTIONS :

1. Use short arc and stringer bead to restrict heat input.
2. Ensure the electrodes are dry. In case of moisture pick-up redry the electrodes at 250-300°C for one hour.

**NOTE :** Batox-D conforming to AWS E316L-15 is also available.