



## RUTOX-F

**CODIFICATION:**                      AWS :    SFA 5.4 E316L-16  
                                                  IS :    5206 E19.12.2L R16

### CHARACTERISTICS AND APPLICATIONS:

Rutox-F is a stainless steel electrode depositing a weld metal containing 18Cr - 13Ni - 2.3Mo, which is unique in combination to produce a maximum ferrite content of 2FN in the weld metal. This extra low ferrite content ensures excellent corrosion resistance against severe corrosive media. Ideal for welding AISI 316L, 316 particularly when the weld metal ferrite content has to be controlled at a low level, as in the case of urea equipments.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr	Ni	Mo	S	P
Percent	: 0.03	1.80	0.45	18.0	13.5	2.3	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L= 4d)%
545	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/Cartron	: 2.5	2.5	2.5	2.5
(kgs)				

**APPROVAL : 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-F conforming to AWS E316L-15 is also available.**