



RUTOX-F(SPL)

CODIFICATION : AWS : SFA 5.4 E316L-16 (Nearest)

CHARACTERISTICS AND APPLICATIONS :

Rutox-F(SPL) is a stainless steel electrode depositing zero ferrite weld metal which displays excellent resistance to corrosion particularly in urea service. The welds are of radiographic quality and possess excellent corrosion resistance. Ideally suited for welding AISI 316L and their equivalents for chemical and fertilizer industries.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element	C	Mn	Si	Cr	Ni	Mo	S	P
Percent	: 0.025	2.0	0.50	17.5	15.0	2.60	0.020	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L= 4d)%	CVN Impact strength at minus 196°C (J)
574	36	27

CURRENT AND PACKING DATA : AC / DC(+)

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

PRECAUTIONS :

1. Welding should be carried out taking care to avoid build up of heat. It is imperative that due control is exercised for keeping interpass temperature low and in any case below 150°C.
2. Size of electrode should be smallest practicable.
3. Arc should be as short as possible.
4. Weaving should be minimised.
5. Electrodes should be redry at 250-300°C for one hour, then cool slowly to 50-60°C and maintained at this temperature before removing from oven for use.