

RATNA 316

A rutile type all position 18 Cr/12 Ni/2.3 Mo stainless steel Electrode.

CLASSIFICATION : AWS/SFA-5.4: E 316-16, DIN E 19 123R 23
IS-5206: E 19.12.2R 26 , BS 19 123R

APPROVAL :

CHARACTERISTICS : A 18 Cr/ 12 Ni/ 2.3 Mo stainless steel electrode with resistance to corrosion, cracking and heat. The weld metal has excellent creep resistance strength, welds are of radiographic quality and resistant to chemical corrosion. The bead appearance is fine and rippled.

APPLICATION :

- 1) Suitable to weld 18/8 Mo steels such as 316/317 type.
- 2) Corrosion resistance applications such as tanks fabrication for storage of phosphoric acid, acetic acid and sulphuric acids.
- 3) Heat resistance is much better than that of 18Cr-8Ni stainless steels welds.
- 4) High resistance to general and intergranular corrosion and to creep.

RE-DRY CONDITION : Re-Dry the electrode at 250°C for 1 hrs before use.

ALL WELD CHEMICAL COMPOSITION %

C	Mn	Si	S	P	Cr	Ni	Mo
0.08 max.	0.50-2.50	1.00 Max	0.030 Max	0.040 Max	17.00-20.00	11.00-14.00	2.00-3.00

ALL WELD MECHANICAL PROPERTIES:

UTS (N/mm ²)	EL % (l=4d)	CHARPY "V" NOTCH IMPACT AT +20 ⁰ C : 60-80 J	FERRITE (FN)
550-660	30-42		3-10

DIEMENSION, CURRENT CONDITION & PACKING DATA

Size(mm) (DXL)	Size(inch) (DXL)	Current Condition (DC-/AC) Amps	kg./pkt.	kg./Case
2.50/ 2.40 X 350	3/ 32" X 14"	60-80	2	20
3.15/ 3.20 X 350	1/ 8" X 14"	80-100	2	20
4.00 X 350	5/ 32" X 14"	110-140	2	20
5.00 X 350	3/ 16" X 14"	140-170	2	20

Customer packing on request.