



## RUTOX-A

<b>CODIFICATION :</b>	AWS :	SFA 5.4 E308-16
	IS :	5206 E19.9 R16
	EN ISO :	3581-A E 19 9 R 3 2

### CHARACTERISTICS AND APPLICATIONS :

Rutox-A is a stainless steel electrode yielding a weld metal of 19Cr - 10Ni. The weld metal displays good resistance to cracking, corrosion and scaling. Ideally suited for welding stainless steel materials of similar composition like AISI 301, 302, 304, 308, etc.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL :

Element :	C	Mn	Si	Cr	Ni	S	P
Percent :	0.05	1.40	0.40	19.5	9.50	0.020	0.020

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS	Elongation
(MPa)	(L= 5d)%
604	38

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

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

**APPROVALS :** Adani Infra, BHEL, CE, EIL, NPCIL, NTPC, PDIL

### PRECAUTIONS :

1. Use short arc, low current and minimum weaving.
2. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.