55 YEARS Since 1966

Estd. 1966
D&H sécheron
Complete Welding Support

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 (MPa)	Elongation (L = 4d)%
545	38.0

CURRENT AND PACKING DATA : AC / DC(+)

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

APPROVAL : PDIL

PRECAUTIONS :

1. Use short arc and stringer bead to restrict heat input.
2. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.

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