



RUTOX-F(U)

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

CHARACTERISTICS AND APPLICATIONS:

Rutox-F(U) is a rutile coated electrode depositing a weld metal which is fully austenitic in structure, has high strength and good crack resistance. The weld metal displays remarkable corrosion resistance particularly in urea service. It is ideally suitable for welding of AISI 316L and their nitrogen bearing versions particularly for urea service.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P	Cr	Ni	Mo	N
Percent	: 0.030	4.0	0.45	0.015	0.025	19.5	16.0	2.8	0.14

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 4d)%
630	37.0

CURRENT AND PACKING DATA: AC/DC (+)

Size (mm)	:	5 x 350	4 x 350	3.15 x 350	2.5 x 350
Dia x Length					
Current Range	:	150-180	110-140	80-100	60-80
(Amps)					
Qty. (kgs/Carton)	:	2.5	2.5	2.5	2.5

PRECAUTIONS:

1. Re-dry the electrodes at 250-300°C for one hour.
2. Use low current, short arc and stringer beads.