



RUTOX-Mo (ST)

CODIFICATION:	AWS :	SFA 5.4 E318-16
	IS :	5206 E19.12.2Nb R16
	EN ISO :	3581-A E 19 12 3 Nb R 3 2

CHARACTERISTICS AND APPLICATIONS:

Rutox-Mo (St) is a stainless steel electrode producing a Niobium stabilised 18Cr - 12Ni - 2.3Mo weld metal. The weld metal possesses good resistance to corrosion and pitting and improved creep strength. The weld metal has excellent resistance to intergranular corrosion. Ideally suited for joining stainless steels of similar composition.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element :	C	Mn	Si	Cr	Ni	Mo	Nb	S	P
Percent :	0.05	1.5	0.42	18.5	12.0	2.3	0.60	0.018	0.020

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL :

UTS (MPa)	Elongation (L= 5d)%
594	35.0

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

APPROVALS : CE, EIL

PRECAUTIONS :

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