



Selectarc 20/10MBC

*Stainless Steel
Rutile Electrode*

Classification

AWS A5.4 : E316L-16
ISO 3581-A : E 19 12 3 L R 3 2

EN 1600 : E 19 12 3 L R 3 2

Description & Applications

Low carbon Rutile-basic-coated Mo containing austenitic stainless steel electrode with approx. 8% ferrite. Coating with very low moisture pick-up. Soft fusion without spatters, very easy slag removal, exceptional bead appearance, easy restriking. For welding and cladding on austenitic Cr-Ni-Mo stainless steels and clad plates. Applied for service temperatures from -120°C up to +400°C in the chemical and petrochemical industries, in refineries, in the food industries and for ship building to weld pipes, tanks, heat exchangers.

Base materials

Stainless steels for general use:

UNS	Alloy	EN 10088	Material N°	UGINE
S31600	316	X5CrNiMo17-12-2	1.4401	UGINOX 17-10 M
S31603	316L	X2CrNiMo17-12-2	1.4404	UGINOX 18-11 ML
J92900		G-X5CrNiMo 19 11 2	1.4408	
S31635	316Ti	X6CrNiMoTi17-12-2	1.4571	UGINOX 17-11 MT
S31635	316Ti	X10CrNiMoTi18-12	1.4573	
S31640	316Cb	X6NiCrMoNb17-12-2	1.4580	
		G-X5CrNiMoNb19-11-2	1.4581	

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Fe
<0.03	0.8	0.7	18.5	12.0	2.7	Rem.

All Weld Metal Mechanical Properties

R _{p0.2} (MPa)	R _m (MPa)	A ₅ (%)	KV (J)
>400	>560	>35	+20°C 70 -120°C 40

Welding Current & Instructions

Electrode	ØxL (mm)	1,6x250	2,0x300	2,5x350	3,2x350	4,0x350	5,0x450
Current	(A)	30	45	70	100	135	180

Redrying at 250°C during 1h, if necessary. Interpass temperature : < 200°C.

ind.12



= + ~ 70V

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