



Selectarc Inox 383

Stainless Electrode
Highly corrosion resistant

Classification

AWS A5.4 : E383-16 EN 1600 : E 27 31 4 Cu L R 1 2
ISO 3581-A : E 27 31 4 Cu L R 1 2

Description & Applications

Rutile-basic coated electrode for welding fully austenitic highly corrosion resistant stainless steels (Sanicro 28 , Uranus B28) of the same composition or lower alloyed. Good weldability in all positions, except vertical down, stable arc, good slag removal, regular finely rippled weld beads. Due to its alloy composition, high Mo-content and Cu, the weld metal is suited against attacks by phosphoric- and sulphuric acids, it shows a high resistance against pitting and stress corrosion in chloride containing media. It is used at operation temperatures up to 400°C.

Main applications: Pulp and paper industry, transport containers, installations of the chemical industry.
(Sanicro is a trade name of Sandvik, Uranus is a trade name of Creusot Loire Industries)

Base materials

UNS	Alloy	EN 10088	Material N°	UGINE / CLI
N08028	28	X1NiCrMoCu31-27-4	1.4563	URANUS B28
N08904	904L	X1NiCrMoCu25-20-5	1.4539	URANUS B6

Typical Weld Metal Composition (%)

C	Si	Mn	Cr	Ni	Mo	Cu	Fe
<0.03	0.8	1.4	27.0	31.0	3.8	1.0	Rem.

All Weld Metal Mechanical Properties

$R_{p0.2}$ (MPa)	R_m (MPa)	A_5 (%)	KV (J)
>380	>580	>35	+20°C >70

Welding Current & Instructions

Electrode	ØxL (mm)	2,5x300	3,2x350	4,0x350
Current	(A)	50-70	70-100	90-130

Redrying 2-3h at 250-300°C. Guide electrodes with a slight declination, weld with a short arc and prevent a high heat input by applying the stringer bead technique (weaving max. 2 times core wire diameter). Interpass temperature : <150°C.

ind.12



= + ~ 70V

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