ESAB RSSC (M)

A basic 19/9 Niobium stabilised stainless steel electrode

Print

Classification AWS A 5.4: E 347-15
IS 5206: E 19.9 Nb B20+

DESCRIPTION

ESAB RSSC (M) is used for providing maximum resistance to cracking, corrosion at high temperature upto 800°C. Niobium provides resistance to intergranular cracking in the temperature range 425°C to 843°C by preventing harmful Chromium carbide precipitation. The weldmetal has excellent creep resistance and is of radiographic quality. The basic type slag reduces the risk of Hydrogen induced cracking. The arc characteristics are smooth with the slag system designed to provide easy control and high welder efficiency.

WELDING CURRENT: DC +

TYPICAL APPLICATIONS

ESAB RSSC (M) is used for welding of AISI 321 and 347 type steels. It is especially designed for the welding of 18/8 steels stabilised with Ti or Nb. Used extensively in food, chemical and aircraft industries. It is also suitable for welding of turbine blades.

TYPICAL ALL WELDMETAL PROPERTIES

Chemical Composition (%)				Mechanical Properties	
C	0.06	Ni	10.0	UTS	610 N/mm^2
Mn	0.95	Nb	0.80	YS	410 N/mm^2
Si	0.35	S	0.018	EL (L=4d)	37%
Cr	20.0	P	0.018	Ferrite	4-8 FN

CURRENT RANGE & PACKING DATA

Size (mm)	Length (mm)	Current Range (Amps)	No. of Electrodes in a	
			Carton	Cardboard box
2.50	350	40-60	80	400
3.15	350	60-90	65	325
4.00	350	85-130	40	200
5.00	350	140-180	30	150

PACKING: Electrodes are packed in heat sealed plastic cartons and five of these cartons are shrink wrapped in a cardboard box