



SUPERON SCHWEISSTECHNIK INDIA LTD.

India's Leader in SS Welding Electrodes & Filler



Approvals



INDIA'S
FIRST FULL LENGTH
WELDING.



India's Finest SS Welding Electrodes

- ★ Perfect **FULL LENGTH** welding >310mm. No red hotness. No waste.
- ★ Self releasing slag & spatter free smooth welding.
- ★ Low moisture absorption - no porosities /blow holes /rework.
- ★ Best in class welding - smooth, finely rippled weld beads. Perfect re-striking.
- ★ Best in class colour matching.
- ★ Best in class vacuum packaging - minimum in transit breakages. No waste.

"Lowest Actual Cost - Best Value for Money"

India's Finest SS Filler Wires



- ★ Warranted chemistry
- ★ Superior Cast & Helix control
- ★ Smooth feedability
- ★ Perfect cleanliness
- ★ Best in class packaging

Product Name		Classification	Mechanical Properties Of Weld Metal (Typical)					Unique Feature (All Vacuum Packed)
		AWS/SFA	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5(%)	Impact (J)	Welding Conditions	
OPTIMAL SERIES STAINLESS STEEL WELDING ELECTRODES								
1	SUPER OPTIMAL 308L	A5.4: E308L-16	—	610	>40	60 at +20°C	DC+;AC	LMA type coating, superior weldability without spatter, self peeling slag. Best in class mechanical properties.
2	SUPER OPTIMAL 309L	A5.4: E309L-16	—	600	>38	60 at +20°C	DC+;AC	Excellent weldability, self peeling slag. Best in class mechanical properties. Best for joining dissimilar steels.
3	SUPER OPTIMAL 309 MOL	A5.4: E309L MO-16	—	600	>35	65 at +20°C	DC+;AC	Extra low carbon. Superior weldability. Nice aspects of bead. High level of delta ferrite. Excellent crack resistant.
4	SUPER OPTIMAL 316L	A5.4: E316L-16	—	>590	>35	>60 at -20°C	DC+;AC	Superior weldability, finely rippled bead, self peeling slag, controlled fluidity, best suitable for pipe welding. Impact passes at -196°C also.
5	SUPER OPTIMAL 308L-15	A5.4: E308L-15	—	590	40	80 at -20°C	DC(+)	Basic coated, superior weldability, self peeling slag, controlled fluidity, best suitable for pipe welding. Impact passes at -196°C also.
6	SUPER OPTIMAL 309L-15	A5.4: E309L-15	—	610	37	70 at +20°C	DC(+)	Basic type, self peeling slag, controlled fluidity, best suitable for all position welding.
7	SUPER OPTIMAL 316L-15	A5.4: E316L-15	—	570	40	80 at -20°C	DC(+)	Basic coated, superior weldability, self peeling slag, controlled fluidity, best for all position welding. Impact passes at -196°C also.
8	SUPER OPTIMAL 347-15	A5.4: E347-15	—	590	38	90 at +20°C	DC(+)	Basic coated, controlled fluidity, superior weldability, self peeling slag, superior intergranular corrosion resistant.
Note: Also Available 308L-17, 309L-17 & 316L-17.								
C-MN, LOW ALLOY AND CHROME - MOLY STEEL WELDING ELECTRODES								
9	SUPER OPTIMAL 6013	A5.1: E 6013	≥400	470-540	≥24	≥70 at 0°C	AC;DC±	Superior slag detachability. Highest impact notch toughness in its class (90J at 0° typical).
10	SUPER OPTIMAL 7016	A5.1: E 7016	≥410	510-640	≥26	≥70 at -30°C	DC+;AC	Self peeling slag. Excellent mechanical properties & weldability.
11	SUPER OPTIMAL 7018	A5.1: E 7018	≥450	550-620	≥28	≥100 at -30°C	DC+;AC	Excellent weldability. Best in class mechanical properties. Less than 4.0 ml diffusible hydrogen level.
12	SUPER OPTIMAL 7018 S	A5.1: E 7018-1	≥450	550-620	≥28	≥90 at -45°C	DC+;AC	Ultra smooth finely rippled weld beads. Less than 3.0 ml diffusible hydrogen level.
13	GARANT Mo 7018 - A1	A5.5: E 7018-A1	≥450	≥550	≥22	≥60 at +20°C	DC+;AC	Excellent weldability. Best suited positional welding. Excellent creep resistant.
14	SUPER CHROMO IB 8018 B2	A5.5: E 8018-B2	≥490	560-720	≥20	≥60 at+20°C	DC+;AC	Ultra smooth finely rippled beed. Best in class mechanical properties.
15	SUPER CHROMO 2B 9018 B3	A5.5: E 9018-B3	≥530	630-720	≥18	≥50 at +20°C	DC+;AC	Excellent weldability and mechanical properties. Low X- and J- factors.
16	GARANT NiMo 9018 - G	A5.5: E 9018-G	560	700	21	160 at +20°C	DC+;AC	Excellent weldability, extra low hydrogen, self peeling slag, best in class mechanical properties.
17	SUPER NiCrMo 11018 - M	A5.5: E 11018-M	730	800	22	≥47 at at -51°C	DC+;AC	Extra low hydrogen, best in class mechanical properties, excellent weldability
STAINLESS STEEL WELDING ELECTRODES								
18	SUPER STAINLESS 307	A5.4: E307-16	—	>600	>35	>70 at +20°C	DC+;AC	Austenitic structure, rutile type, excellent weldability. Nice aspects of bead. Excellent machinability.
19	SUPER STAINLESS 308	A5.4: E308-16	—	610	38	>55 at +20°C	DC+;AC	Superior Weldability with self peeling slag. Finely rippled flat bead.
20	SUPER STAINLESS 308L	A5.4: E308L-16	—	600	40	>55 at +20°C	DC+;AC	Rutile basic LMA type coating, excellent weldability. Exceptional weld bead.
21	SUPER STAINLESS 309	A5.4: E309-16	—	620	>35	60 at +20°C	DC+;AC	LMA type coating, ferrite balanced, finely rippled bead self peeling slag.
22	SUPER STAINLESS 309L	A5.4: E309L-16	—	600	>36	60 at +20°C	DC+;AC	Superior weldability, exceptional bead appearance excellent for dissimilar welding.
23	SUPER STAINLESS 309 MOL	A5.4: E309L MO-16	—	600	>35	60 at +20°C	DC+;AC	Superior weldability, finely rippled bead, self peeling slag. Superior crack resistant.

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STAINLESS STEEL WELDING ELECTRODES								
24	SUPER STAINLESS 310	A5.4: E310-16	—	580	>35	75 at +20°C	DC+;AC	Superb weldability, fully austenitic structure. Scale resistant upto 1200°C. Hot cracking & chemical corrosion resistant.
25	SUPER STAINLESS 312	A5.4: E312-16	>500	>800	>25	-	DC+;AC	Superior weldability. Excellent crack, heat and shock resistant, highest tensile strength with elongation in class.
26	SUPER STAINLESS 316	A5.4: E316-16	-	590	>36	>60 at -20°C	DC+;AC	LMA type coating, superior weldability Excellent corrosion resistant.
27	SUPER STAINLESS 316L	A5.4: E316-16	-	>550	>38	>60 at -20°C	DC+;AC	Spatterless superior weldability. Finely ripple flat bead. Excellent corrosion resistant.
28	SUPER STAINLESS 317L	A5.4: E 317L-16	-	590	>34	50 at +20°C	DC+;AC	Excellent crevice and pitting corrosion resistant, self peeling slag, finely rippled weld bead.
29	SUPER STAINLESS 318	A5.4: E 318-16	-	590	>28	65 at +20°C	DC+;AC	Excellent intergranular corrosion resistant, good weldability, self peeling slag.
30	SUPER STAINLESS 347	A5.4: E347-16	-	580	>36	>60 at +20°C	DC+;AC	Rutile basic-LMA type coating. Superior intergranular corrosion resistant.
31	SUPER STAINLESS DX	A5.4: E 2209-17	-	750	>22	50 at +20°C	DC+;AC	Duplex, excellent intergranular corrosion, pitting and stress corrosion resistant, self peeling slag, spatter free arc.
32	SUPER STAINLESS DX(S)	A5.4: E 2594-17	-	820	>18	47 at +20°C	DC+;AC	Super-duplex, excellent pitting and crevice corrosion resistant, smooth arc, self peeling slag.
33	SUPER STAINLESS 308L-15	A5.4: E308L-15	-	580	>38	80 at -20°C	DC(+)	Basic coated, spatterless superior weldability. Impact passes at -196°C.
34	SUPER STAINLESS 309L-15	A5.4: E309L-15	-	≥550	>35	60 at +20°C	DC(+)	Basic coated, superior weldability, best in class mechanical properties.
35	SUPER STAINLESS 316L-15	A5.4: E316-15	-	≥570	>36	80 at -20°C	DC(+)	Basic coated, superior weldability, self peeling slag, impact passes at -196°C.
36	SUPER STAINLESS 347-15	A5.4: E347-15	-	570	>36	80 at +20°C	DC(+)	Basic coated, self peeling slag, superior weldability. Superior intergranular corrosion resistant.
CAST IRON WELDING ELECTRODES								
37	SUPER CAST NIFE	E NiFe-C1	-	>480	-	195 BHN	DC+;AC	Ferro-nickel, excellent for joining and repairing. Best in class machinability. Superior weldability with easy slag removal.
38	SUPER CAST AC - 45	E NiFe-C1	-	>500	-	210 BHN	DC+;AC	Superb weldability, easy slag removal. Crack resistant. Good machinability.
39	SUPER CAST AC - 55	E NiFe-C1	-	>500	-	195 BHN	DC+;AC	Excellent weldability with easy slag removal. Highly crack resistant, excellent for joining & repairing.
Note: Also Available Cutting & Gouging Welding Electrodes								

Manufactured Under Licence In India By



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