



IN COLLABORATION WITH:
Kjellberg
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Kjellberg Finsterwalde Elektroden und Maschinen GmbH, Germany

SUPERON SCHWEISSTECHNIK INDIA LTD.

Leader in SS Welding Electrodes



- ★ Superior Weldability
- ★ Superior Mechanical Properties
- ★ Superior Recovery
- ★ Superior Packaging
- ★ Superior Reliability



Product Name	Classification	Mechanical Properties Of Weld Metal (Typical)					Applications (All Vacuum Packed)
	AWS/SFA	Yield Strength N/mm2	Tensile Strength N/mm2	Elongation A5(%)	Impact (J) RT	Welding Conditions	
SS WELDING ELECTRODES:							
SUPER IMPULSE 308 L	E 308L-16	-	590	40	> 55	DC+; AC	Spatterless superior weldability, self peeling slag. Finely rippled bead.
SUPER MARATHON 308 L	E 308L-16	-	590	40	> 55	DC+; AC	LMA type coating, excellent weldability. Superior ferrite balanced. Self peeling slag.
SUPER OPTIMAL 308 L	E 308L-16	-	610	44	> 60	DC+; AC	LMA type coating, superior weldability without spatter, self peeling slag. Best in class mechanical properties.
SUPER STAINLESS 308 L	E 308L-16	-	600	40	> 55	DC+; AC	Rutile basic LMA type coating, excellent weldability. Exceptional weld bead.
SUPER STAINLESS 308	E 308-16	-	600	38	> 55	DC+; AC	Superior weldability with self peeling slag. Finely rippled flat bead.
SUPER STAINLESS 347	E 347-16	-	590	40	> 60	DC+; AC	Rutile basic-LMA type coating. Superior intergranular corrosion resistant.
SUPER MARATHON 316 L	E 316L-16	-	> 550	> 35	> 60	DC+; AC	LMA type coating, superior corrosion resistant. Excellent weldability.
SUPER OPTIMAL 316 L	E 316L-16	-	> 590	> 35	> 60	DC+; AC	Superior weldability, finely rippled bead, self peeling slag. Best in class corrosion resistant, Best in class mechanical properties.
SUPER STAINLESS 316 L	E 316L-16	-	> 550	> 35	> 60	DC+; AC	Spatterless superior weldability. Finely rippled flat bead. Excellent corrosion resistant.
SUPER STAINLESS 316	E 316-16	-	590	39	> 60	DC+; AC	LMA type coating, superior weldability. Excellent corrosion resistant.
SUPER STAINLESS 307	E 307-16	-	> 600	> 35	> 75	DC+; AC	Austenitic structure, rutile type, excellent weldability. Nice aspects of bead. Excellent machinability.
SUPER MARATHON 309 L	E 309L-16	-	600	> 38	60	DC+; AC	LMA type coating, spatterless smooth weldability. Extra strong & tough for joining dissimilar steels.
SUPER OPTIMAL 309 L	E 309L-16	-	600	> 38	60	DC+; AC	Excellent weldability, self peeling slag. Best in class mechanical properties. Best for joining difficult to weld steels.
SUPER STAINLESS 309 L	E 309L-16	-	600	> 38	60	DC+; AC	Superior weldability, exceptional bead appearance, excellent for dissimilar welding.
SUPER STAINLESS 309	E 309-16	-	600	> 35	60	DC+; AC	LMA type coating, ferrite balanced, finely rippled bead. Self peeling slag.
SUPER MARATHON 309 MOL	E 309MOL-16	-	600	> 35	65	DC+; AC	Rutile - basic, LMA type coating, superior weldability. Self peeling slag. Highly crack resistant.
SUPER OPTIMAL 309 MOL	E 309MOL-16	-	600	> 35	65	DC+; AC	Extra low carbon. Superior weldability. Nice aspects of bead. High level of delta ferrite. Excellent crack resistant.
SUPER STAINLESS 309 MOL	E 309MOL-16	-	600	> 35	65	DC+; AC	Superior weldability, finely rippled bead, self peeling slag. Superior crack resistant.
SUPER STAINLESS 310	E 310 -16	-	620	35	75	DC+; AC	Superb weldability, fully austenitic structure. Scale resistant upto 1200° C. Hot cracking & chemical corrosion resistant.
SUPER STAINLESS 312	E 312 -16	> 500	> 800	> 25	-	DC+; AC	Superior weldability. Excellent crack, heat and shock resistant, highest tensile strength with elongation in class.
CAST IRON WELDING ELECTRODES:						Hardness	
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.
SUPER CAST AC - 45	E NiFe-C1	-	> 500	-	210 BHN	DC±; AC	Superb weldability, easy slag removal. Crack resistant. Good machinability.
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.

Manufactured In India By



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