



## BETANOX DMO

STAINLESS STEEL (Dissimilar Steel Welding)



A Stainless steel Electrode depositing 23/12/2.5Mo alloy

**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

**IS 5206**

E 23 12 2 R 12

E 309Mo-16

E 23.12.2 R26

### KEY FEATURES :

- Rutile coated electrode
- High ferrite content ensures maximum cracking resistance
- Mo addition provides high strength and corrosion resistance
- Deposit is 23/12/2.5Mo type
- Excellent corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic quality welds

### WELDING POSITION :



**AC (70 OCV)/DCEP**

### TYPICAL APPLICATIONS :

- Welding of AISI 309 Mo type steels
- Dissimilar joints between 316 type and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels before deposition of 316 type weld metal

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Mn</b>
	0.06	23.5	12.8	2.4	1.0
Specification	0.12 max	22.0-25.0	12.0-14.0	2.0-3.0	0.5-2.5
	<b>Si</b>	<b>P</b>	<b>S</b>	<b>Cu</b>	
	0.6	0.02	0.02	0.2	
Specification	1 max	0.04 max	0.03 max	0.75 max	

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>	<b>Ferrite No.</b>
Typical	As Welded	650	36	14
Specification		550	30 min	12-15

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.0 x 300	50-75	2	5	10
2.5 x 350	80-100	2	5	10
3.15 x 350	110-140	2	5	10
4.0 x 350	150-180	2	5	10

**EQUIVALENT : GMAW wire: Miginox 309Mo**

**GTAW filler: Tiginox 309Mo**