BETANOX 20/25/5/Cu AWS A/SFA 5.4 E385-16

STAINLESS STEEL (Heat Resisting)

CLASSIFICATION:

ISO 3581-B
E 20 25 5 Cu N L R 12

IS 5206
E 20.25.5 LCu R 26

KEY FEATURES:

- Rutile based semi basic coating
- Low carbon 20/25/5/Cu type fully austenitic deposit
- Recommended for highly corrosive conditions in the chemical industries, sea water desalinization plants
- Resistant to pitting and crevice corrosion in chloride bearing media
- Radiographic quality weld deposit
- Resist intergranular corrosion and sulfide stress corrosion cracking
- Scaling resistance upto 1200°C and operating temperatures upto 400°C
- Smooth arc and medium penetration
- Least spatter and easy slag removal
- Finely rippled smooth bead

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of 904L, HV-9A, HV-9 stainless steel and similar alloys for high temperature and/or high corrosion service
- Welding of 904L steel to other grades of stainless steel
- Welding of austenitic stainless steels with enhanced corrosion resistance to reducing media
- Suitable for materials 1.4539, 1.4439, 1.4537, 1.4505, 1.4506, 1.4531, 1.4536, 1.4573, 1.4585, 1.4586

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	Cu
0.02	1.5	0.55	20.9	24.1	4.4	1.45

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	575	37
Specification		520 min	30 min

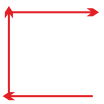
PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A
2.0 x 300	50-70
2.5 x 350	70-100
3.15 x 350	90-130
4.0 x 350	140-180

AC (70 OCV) /DCEP

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

All Positions, except vertical Downwards



Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.

EQUIVALENT:

GMAW	GTAW
Miginox 385	Tiginox 385

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