



# BETANOX 316 PLUS

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E316-17**

### CLASSIFICATION:

**ISO 3581-A**  
E 19 12 3 L R 13

**IS 5206**  
E19.12.2 LR36

**APPROVALS:** CE

### KEY FEATURES:

- Acid-Rutile based coating
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Resistant to variety of acids e.g. Sulphuric, Hydrochloric, Acetic, Phosphoric, Citric, Tartaric etc.
- Easy slag removal
- Controlled ferrite content of 4-8 for maximum cracking resistance
- 19/10/2 Mo type SS electrode
- Radiographic quality weld deposit
- Excellent slag removal

### TYPICAL APPLICATIONS:

- Welding Mo bearing austenitic alloys such as AISI 316, 316L, 317
- Suitable for material no. 1.4401 and similar grades
- Welding of equipments in Chemical, Paper and pulp, Paint and dye industries

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

C	Mn	Si	Cr	Ni	Mo
0.02	1.0	19.3	11.35	13.1	2.3

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	580	36	6
Specification		520 min	30 min	3-8

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 <b>AC (70 OCV) /DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	Flat butt and fillet welds only  
3.15 x 350	80-100		
4.0 x 350	110-140		

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