



BETANOX 316L PLUS

STAINLESS STEEL (Austenitic Steel)

AWS A/SFA 5.4 **E316L-17**

CLASSIFICATION:

ISO 3581-A
E (19 12 3 L) R 13
IS 5206
E19.12.2 LR36

KEY FEATURES:

- Acid-Rutile based coating
- Extra low carbon 18/13/2.5Mo type weld deposit
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Easy slag removal
- Resist Stress Corrosion Cracking, Hot cracking, Chemical corrosion at high temperature
- Smooth arc characteristics
- Radiographic quality weld deposit

APPROVALS: CE

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	0.7	1.0	19.3	11.35	2.3

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	580	36	6
Specification		490 min	30 min	3-8

PARAMETERS - PACKING DATA:

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

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

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 316L	Tiginox 316L	Miginox FC 316L	Automelt S33	Subinox 316L