



BETANOX D

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E309-16**

CLASSIFICATION:

ISO 3581-A
E (23 12) R 12

IS 5206
E 23.12 R26

KEY FEATURES:

- Rutile type medium coating
- 23/12 type SS deposit
- Exhibit excellent corrosion and oxidation resistance upto 1100°C
- Highest resistance to cracking
- Low dilution on mild and low alloy steels due to higher alloy content
- All position capability
- Radiographic quality weld

APPROVALS: LRA/IBR/CE

TYPICAL APPLICATIONS:

- Dissimilar joints between stainless steels and low alloy or carbon steels
- Welding of AISI 309 type steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels


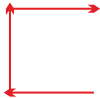
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.03	0.9	0.7	23.5	12.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	610	38
Specification		550 min	30 min

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 REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
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Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kg each.