



BETANOX DCb

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E309Nb-16**

CLASSIFICATION:

ISO 3581-A

E 23 12 Nb R 12

IS 5206

E 23.12 Nb R26

KEY FEATURES:

- Rutile coated electrode
- Deposit is 23/12/Nb stabilized
- Low dilution on mild and low alloy steels due to higher alloy content
- Intergranular corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic weld quality

APPROVALS: IBR/CE

TYPICAL APPLICATIONS:

- Welding of AISI 309, 309 Nb stabilized steels
- Dissimilar joints between 347 type and low alloy or carbon 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	Nb
0.04	0.9	0.5	23	12.1	0.8

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	600	36
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.5 x 350	50-75	 AC (70 OCV) /DCEP All Positions, except vertical Down  REDRYING CONDITION: 250-300°C for minimum 1 hr.
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.