



BETANOX 308 PLUS

CLASSIFICATIONS

AWS A/SFA 5.4 E 308-17
 IS 5206 E 19.9 R26

COATING TYPE: Acid-Rutile
 COATING FACTOR: Medium

IDENTIFICATION: Brand Printed

APPROVALS

DNV E 308-17 LRS E308-17
 KPG E 308-17 PDIL E308-17

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5	2.0
130-	100-	60-	50-	35-
180	140	100	75	50

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 2 Hrs

(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

CHARACTERISTICS

A 19/10 SS electrode with controlled Ferrite content of 3 to 7% for maximum resistance to cracking, atmospheric corrosion. The weld metal is of radiographic quality. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

TYPICAL APPLICATIONS

For the welding of 18/8 SS, represented by AISI types 301, 302, 304 and 308; and German steel Nos. 4016, 4501, 4300, 4301 on continental steel V2A, Ugine NS 22S NS 21S, Avesta 832 MV; Soderfors 553, Sandvik OR-2; UHB etc. Dump impellers, Steels of difficult weldability such as certain grades steel, for building-up stainless surfaces on centrifugal pump impellers and shafts, valve faces, seats and chemical plants.

MECHANICAL PROPERTIES- ALL-WELD			
Condition	UTS MPa	% Elong. (L=4Xd)	RA %
AW	550-650	35-50	50 min.

AW : As-welded

WELD METAL CHEMISTRY, wt%		
C - 0.07 max.	S - 0.03 max.	Cr - 18.0-21.0
Mn - 0.50-2.0	P - 0.03 max.	Cu - 0.50 max.
Si - 0.9 max.	Ni - 9.0-11.0	

PACKING DATA				
Dia., mm	4.0	3.2	2.5	2.0
Length, mm	300	300	300	300
Wt. per carton, kgs	6	6	6	6
Cartons/ box	3	3	3	3
Wt. per box, kgs	18	18	18	18

Related Products: Tiginox 308L, Superinox-1C, Superinox-1A, Betanox-308L Plus, Tiginox 308L Plus, Tiginox 308L, Automelt 308L wire + Automelt S76 flux