



# BETANOX 309Cb PLUS

## CLASSIFICATIONS

AWS A/SFA 5.4 E 309 Cb-17  
 IS 5206 E 23.12 Cb R26

COATING TYPE: Acid-Rutile  
 COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: AC, DC (+)				
5.0	4.0	3.2	2.5	2.0
150-	110-	80-	50-	35-
180	140	100	75	45

## CHARACTERISTICS

An electrode to deposit 25/12 Cb stabilised SS which has excellent resistance to intergranular corrosion and higher strength at elevated temp. service upto 1100°C. 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.

## WELDING POSITIONS

F, H, V-up, OH

## REDRYING CONDITIONS

300°C for 1 hour  
 (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

## TYPICAL APPLICATIONS

Welding of AISI 309-Cb type, Joining SS(347 type) to Low alloy steels or Carbon steels. Deposition of buffer layer on Carbon steel or low alloy steels before deposition of 18/8 (stabilized) type of weld metal.

MECHANICAL PROPERTIES- ALL-WELD		
Condition	UTS MPa	% Elong. (L=4Xd)
AW	570-690	30-40

AW: As-welded

WELD METAL CHEMISTRY, wt%		
C - 0.10 max.	S - 0.03 max.	Cr - 22.0-25.0
Mn - 0.5-2.5	P - 0.03 max.	Cb - 0.70-1.00
Si - 0.90 max.	Ni - 12.0-14.0	Cu - 0.50 max.

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

Related Products: Betanox-D + Cb