



# BETANOX 316 PLUS

**CLASSIFICATIONS**

AWS A/SFA 5.4 E 316-17  
 IS 5206 E 19.12.2 R26

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

**CHARACTERISTICS**

A 19/10 Mo SS electrode with controlled Ferrite content of 4 to 8% for maximum resistance to cracking. The weld metal is of radiographic quality. Weld metal is resistant to Sulphuric, Hydrochloric, Acetic, Phosphoric, Citric, Tartaric acid etc. 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 19/12 Mo SS, represented by AISI types 316, 317; For welding of equipments on chemical industries, Paper and pulp industry. Paint and dye industries.

**APPROVALS**

DNV E 316-17 PDIL E 316-17  
 LRS E 316-17

**CURRENT CONDITIONS: AC, DC (+)**

5.0	4.0	3.2	2.5	2.0	1.6
150-	110-	80-	50-	35-	25-
180	140	100	75	45	35

**WELDING POSITIONS**

F, H, V-up, OH

**REDRYING CONDITIONS**

300°C for 2 hours  
 (Optionally also available in vacuum-packed condition, redrying not required in this packaging)

MECHANICAL PROPERTIES- ALL-WELD				
Condition	UTS MPa	% Elong. (L=4Xd)	RA %	Ferrite No.
AW	530-650	30-40	50 min.	4-8

AW : As-welded

WELD METAL CHEMISTRY, wt%		
C - 0.08 max.	S - 0.03 max.	Cr - 17.0-20.0
Mn - 1.0-2.5	P - 0.04 max.	Mo - 2.0-3.0
Si - 0.30-0.90	Ni - 11.0-14.0	

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 316L, Superinox-2A, Superinox-2C, Betanox-316L Plus, Miginox 316L, Subinox 316L wire + Automelt S76 flux