



BETANOX 310 PLUS

CLASSIFICATIONS

AWS A / SFA 5.4 E 310-17
 IS 5206 E 25.20 R26X

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

CHARACTERISTICS

An electrode to deposit 25/20 SS which has excellent stability and oxidation resistance in continuous service upto 1150°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.

TYPICAL APPLICATIONS

Welding AISI 310 type, German Steels 4762, 4828, 4841, 4846 and 4848, cladding side of stainless clad steels, straight chrome steels and dissimilar steels, hydrogenation and polymerisation plant, gas turbine combustion chamber parts, high temperature furnace parts, annealing boxes and carburising pots.

CURRENT CONDITIONS: AC, DC (+)

130-	100-	60-	50-	35-
5.0	4.0	3.2	2.5	2.0
180	140	100	75	45

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)

MECHANICAL PROPERTIES- ALL-WELD			
Condition	UTS MPa	% Elong. (L=4Xd) 30 min.	CVN Impacts,J @ -196°C 35-65J
AW	550-650		

AW : As-welded

WELD METAL CHEMISTRY, wt%			
C - 0.08-0.15	S - 0.03 max.	Cr - 25.0-28.0	
Mn - 1.0-2.5	P - 0.03 max.	Cu - 0.50 max.	
Si - 0.30-0.80	Ni - 20.0-22.5		

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 310, Betanox-c, Betanox-c-15 Miginox 310, Subinox 310 wire + Automelt S76 flux