



BETANOX D

CLASSIFICATIONS

AWS A/SFA 5.4 E 309-16
IS 5206 E 23.12 R26

COATING TYPE: Rutile

COATING FACTOR: Medium-Heavy IDENTIFICATION: Brand Printed

CHARACTERISTICS

An electrode to deposit 25/12 SS which has excellent corrosion and oxidation resistance in continuous 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.

TYPICAL APPLICATIONS

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

MECHANICAL PROPERTIES- ALL-WELD			
Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
AW	560-660	30-45	12-15

AW : As-welded

WELD METAL CHEMISTRY, wt%		
C - 0.10 max.	S - 0.03 max.	Cr - 22.0-25.0
Mn - 1.0-2.5	P - 0.03 max.	
Si - 0.90 Max	Ni - 12.0-14.0	

APPROVALS

BPCL E 309-16 RDSO Cl. M4
KPG E 309-16 TEIL E309-16

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5	2.0
150-	110-	80-	50-	35-
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)

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 309L, Betanox 309 Plus, Betanox-DL, Miginox 309L, Subinox 309L wire + Automelt S76 flux