



BETANOX 309Mo PLUS

CLASSIFICATIONS

AWS A/SFA 5.4 E 309 Mo-17
IS 5206 E 23.12.2 R26

COATING TYPE: Acid-Rutile

COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CHARACTERISTICS

An electrode to deposit 25/12/2.5Mo SS which has excellent corrosion resistance. 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 309Mo type, Joining SS(316 type) to Low alloy steels or Carbon steels. Deposition of buffer layer on Carbon steel or low alloy steels before deposition of 316 type of weld metal.

APPROVALS

PDIL E 309Mo-17

CURRENT CONDITIONS: AC, DC (+)

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

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)	Ferrite No.
AW	590-710	30-40	12-15

AW : As-welded

WELD METAL CHEMISTRY, wt%

C - 0.12 max.	S - 0.03 max.	Cr - 22.0-25.0
Mn - 0.5-2.5	P - 0.03 max.	Mo - 2.0-3.0
Si - 0.90 max.	Ni - 12.0-14.0	Cu - 0.50 max.

PACKING DATA

	4.0	3.2	2.5	2.0
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 309Mo, Betanox-D Mo, Miginox 309 Mo, Subinox 309Mo wire + Automelt S76 flux