

BETANOX 20/30

AWS A/SFA 5.4 E320-15

STAINLESS STEEL (Heat Resisting)

CLASSIFICATION:

ISO 3581-B
ES320-15

KEY FEATURES:

- Basic coated electrode
- 20/33/2/CuNb stabilized fully austenitic weld
- High strength and excellent oxidation resistance upto 1200°C
- Low spatter loss
- Resistance to corrosion in sulphuric acid, mineral and organic acids
- Smooth and uniform weld beads
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Joining difficult to weld steels such as armor plates and ferritic stainless steels as well as dissimilar steels
- Furnace parts, Annealing boxes and carburizing pots, Gas turbine combustion chamber parts, hydrogenation and polymerization plant
- Welding of AISI 310 and similar grades
- Cladding side of stainless steels and dissimilar steels
- Suitable for materials 1.4710, 1.4713, 1.4745, 1.4762, 1.4823, 1.4832, 1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	Nb	Cu
0.04	1.2	0.55	19.3	32.5	2.3	0.45	3.6

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	620	36
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	50-75	 AC (70 OCV) /DCEP	All Positions, except vertical Downwards
2.5 x 350	80-100		
3.15 x 350	110-140		
4.0 x 350	150-180		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.