



BETANOX 2553

STAINLESS STEEL (Duplex SS)



A high strength super duplex stainless steel Electrode for pitting resistance

CLASSIFICATION : ISO 3581-B

AWS A/SFA 5.4

E 25 9 3Cu N L R 12

E 2553-16

KEY FEATURES :

- Rutile coated non-synthetic electrode
- Super duplex stainless steel deposit
- Exhibit excellent high strength
- Improved resistance to pitting, corrosive attack and to stress corrosion cracking
- Duplex microstructure consists of austenitic-ferritic matrix
- Easy slag removal
- All position capability
- Radiographic quality weld

WELDING POSITION :



AC (70 OCV) /DCEP

TYPICAL APPLICATIONS :

- Welding of duplex and super duplex stainless steels and similar grades
- Pumps and valves, corrosion resisting parts, process equipment for use in offshore oil and gas industries
- Pulp, paper and textile industries, chemical and petrochemical plant
- Suitable for materials 1.4515, 1.4517, ASTM A 240, A 351, A 890 Gr. 1A/1B

REDRYING CONDITION : 250-300°C for minimum 1 hr.

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	Cu	N	S	P
Typical	0.04	1.1	0.5	25.7	7.7	3.5	1.9	0.15	0.02	0.02
Specification	0.06 max	0.5-1.5	1.0 max	24-27	6.5-8.5	2.9-3.9	1.5-2.5	0.10-0.25	0.03 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.	PREN
Typical	As Welded	790	21	47	52
Specification		760 min	15 min	30-55	40 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-70	2	5	10
2.5 x 350	70-90	2	5	10
3.15 x 350	90-140	2	5	10
4.0 x 350	140-180	2	5	10