

# BETANOX 2553

AWS A/SFA 5.4 E2553-16

STAINLESS STEEL (Duplex SS)

## CLASSIFICATION:

ISO 3581-B  
ES2553-16

## KEY FEATURES:

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

**APPROVALS:** CE

## 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



## TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo	N	Cu
0.02	0.6	0.7	24.5	6.9	3.5	0.15	1.9

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.	PREN
Typical	PWHT: 607°C for 1 hr	790	21	47	52
Specification		760 min	15 min	30-55	35 min

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.0 x 300 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 50-70 70-90 90-140 140-180	 <b>AC (70 OCV) /DCEP</b>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.