

BETANOX 309 PLUS

AWS A/SFA 5.4 E309-17

STAINLESS STEEL (Dissimilar Steel Welding)

CLASSIFICATION:

ISO 3581-A

E (23 12) R 13

IS 5206

E 23.12 R36

KEY FEATURES:

- Acid-Rutile based coating
- 23/12 type SS deposit
- Exhibit excellent corrosion and oxidation resistance upto 1100°C
- Resistant to cracking
- Low dilution on mild and low alloy steels due to higher alloy content

APPROVALS: CE

TYPICAL APPLICATIONS:

- Dissimilar joints between stainless steels and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels
- Welding of AISI 309 type steels
- Joining corrosion resistant clad steels

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.025	0.75	0.7	23.7	12.1

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	640	37
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.0 x 300 2.5 x 350 3.15 x 350	Amperage, A 50-75 80-100 110-140	 AC (70 OCV) /DCEP	Flat butt and fillet welds only 
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.

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 309	Tiginox 309	Miginox FC 309	Automelt S33	Subinox 309