



BETANOX 309 PLUS

STAINLESS STEEL (Dissimilar Steel Welding)



A Stainless steel Electrode for dissimilar steel joining

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E (23 12) R 13

E 309-17

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

WELDING POSITION :



AC (70 OCV) /DCEP

TYPICAL APPLICATIONS :

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.05	24.2	12.8	0.2	1.5
Specification	0.15 max	22.0-25.0	12.0-14.0	0.75 max	0.5-2.5
	Si	P	S	Cu	
	0.6	0.02	0.02	-	
Specification	1 max	0.04 max	0.03 max	0.75 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

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

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	50-75	2	5	10
3.15 x 350	80-100	2	5	10
4.0 x 350	110-140	2	5	10