

BETANOX 310 PLUS

AWS A/SFA 5.4 E310-17

STAINLESS STEEL (Heat Resisting)

CLASSIFICATION:

ISO 3581-A
E 25 20 R 13

IS 5206
E 25.20 R36X

KEY FEATURES:

- Acid-Rutile based coating
- 25/20 SS type deposit
- Provides excellent stability and high temperature oxidation resistance upto 1150°C
- Excellent resistance to cracking & fissuring
- Stable arc and low spatter loss
- Easy slag removal
- 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
0.13	1.6	0.6	27.1	21

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	610	37
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.5 x 300 3.15 x 350 4.0 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
Miginox 310	Tiginox 310