

# BETANOX 318 PLUS

AWS A/SFA 5.4 E318-17

STAINLESS STEEL (Austenitic Steel)

## CLASSIFICATION:

ISO 3581-A  
E 19 12 3 Nb R 13  
IS 5206  
E 19.12.2 Nb R36

## KEY FEATURES:

- Acid-Rutile based electrode
- Low carbon 18/13/Mo/Nb stabilized weld deposit
- Controlled ferrite prevent fissuring
- Resistant to stress corrosion & inter-crystalline corrosion cracking
- Radiographic quality welds
- Good corrosion resistance to Sulphuric and organic acids
- Working temperatures upto 400°C
- Easy strike and re-striking
- Easy slag removal

**APPROVALS:** - CE

## TYPICAL APPLICATIONS:

- Welding of Nb and Ti stabilized SS such as AISI 316, 318 and equivalent grades
- Welding of equipments in chemical, paper and pulp, paint and dye industries
- Suitable for materials AISI 316L, 316Ti, 316Cb, 1.4301, 1.4401, 1.4404, 1.4435, 1.4436, 1.4437, 1.4541, 1.4550, 1.4571, 1.4580, 1.4581, 1.4583



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

C	Cr	Ni	Mo	Mn	Si	Nb + Ta
0.04	18.3	12.8	2.2	1.9	0.5	0.4

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	615	36	5
Specification		550 min	30 min	4-8

## PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A	
2.0 x 300	50-75	 AC (70 OCV) /DCEP <span style="float: right;">Flat butt and fillet welds only</span>  <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.
2.5 x 350	80-100	
3.15 x 350	110-140	
4.0 x 350	150-180	

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.