



BETANOX 318 PLUS

STAINLESS STEEL (Austenitic Steel)



Stabilized 18/13/2 Mo type stainless steel Electrode

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E 19 12 3 Nb R 13

E 318-17

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

WELDING POSITION :



AC (70 OCV) /DCEP

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.04	18.3	12.8	2.2	1.9
Specification	0.08 max	17.0-20.0	11.0-14.0	2.0-3.0	0.5-2.5
	Si	P	S	Cu	Nb plus Ta
	0.5	0.02	0.02	-	0.4
Specification	1 max	0.04 max	0.03 max	0.75 max	6xC, min to 1.00 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

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

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-75	2	5	10
2.5 x 350	80-100	2	5	10
3.15 x 350	110-140	2	5	10
4.0 x 350	150-180	2	5	10