

BETANOX DCb

AWS A/SFA 5.4 E309Nb-16

STAINLESS STEEL (Dissimilar Steel Welding)

CLASSIFICATION:

ISO 3581-A
E 23 12 Nb R 12

IS 5206
E 23.12 Nb R26

KEY FEATURES:

- Rutile coated electrode
- Deposit is 23/12/Nb stabilized
- Low dilution on mild and low alloy steels due to higher alloy content
- Intergranular corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic weld quality

APPROVALS: IBR/CE

TYPICAL APPLICATIONS:

- Welding of AISI 309, 309 Nb stabilized steels
- Dissimilar joints between 347 type and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels


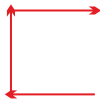
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Nb
0.04	0.9	0.5	23	12.1	0.8

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	600	36
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.0 x 300 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 50-75 80-100 110-140 150-180	 AC (70 OCV) /DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.