



BETANOX DL

STAINLESS STEEL (Dissimilar Steel Welding)



A low carbon stainless steel Electrode for buffer layer and dissimilar steel joining

CLASSIFICATION : ISO 3581-A	AWS A/SFA 5.4	IS 5206	APPROVALS:
E 23 12L R 12	E 309L-16	E 23.12 LR26	IRS/NPCIL

KEY FEATURES :

- Rutile type coating
- High ferrite content for highest resistance to cracking
- Low dilution on mild and low alloy steels due to higher alloy content
- Extra low carbon 23/12 type deposit
- Exhibit excellent corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic quality welds

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Dissimilar joints between stainless steels and low alloy or carbon steels
- Welding of AISI 309, 309L type steels
- For 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
	0.03	23.9	13.2	0.2	1.7
Specification	0.04 max	22.0-25.0	12.0-14.0	0.75 max	0.5-2.5
	Si	P	S	Cu	
	0.5	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%	Ferrite No.
Typical	As Welded	560	36	12
Specification		520	30 min	10-15

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

EQUIVALENT : GMAW wire: Miginox 309L GTAW filler: Tiginox 309L FCAW wire: Miginox FC 309L