

# BETANOX DMoL

AWS A/SFA 5.4 E309LMo-16

STAINLESS STEEL (Dissimilar Steel Welding)

## CLASSIFICATION:

ISO 3581-A  
E (23 12 2L) R 12

IS 5206  
E 23.12.2 LR26

## KEY FEATURES:

- Rutile coated electrode
- Extra low carbon 23/12/2.5Mo type weld deposit
- Low carbon ensures resistance to intergranular corrosion and cracking
- Mo addition provides high strength
- Excellent corrosion and oxidation resistance at elevated temperatures
- All position capability
- Radiographic quality welds

**APPROVALS:** IBR/CE

## TYPICAL APPLICATIONS:

- Welding of AISI 316, 316L type steels
- Buffer layer on low alloy and carbon steels to improve corrosion and wear resistance
- Joining difficult to weld steels
- Dissimilar joints between austenitic stainless steels containing Mo and low alloy or carbon steels



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

C	Mn	Si	Cr	Mo	Ni
0.025	0.7	0.9	23.6	2.1	13

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	600	37
Specification		550 min	30 min

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.0 x 300 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 50-75 80-100 110-140 150-180	 <b>AC (70 OCV) /DCEP</b>  <b>REDRYING CONDITION:</b> 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.

## EQUIVALENT:

GMAW	GTAW	SAW	
		Flux	Wire
Miginox 309LMo	Tiginox 309LMo	Automelt S33	Subinox 309LMo