



BETANOX DMO L

STAINLESS STEEL (Dissimilar Steel Welding)



Extra low carbon stainless steel Electrode depositing 23/12/2.5Mo alloy

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E (23 12 2L) R 12

E 309LMo-16

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

WELDING POSITION :



AC (70 OCV)/DCEP

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

| | C | Cr | Ni | Mo | Mn |
|---------------|-----------|-----------|-----------|-----------|-----------|
| | 0.03 | 23.2 | 12.7 | 2.5 | 1.6 |
| Specification | 0.04 max | 22.0-25.0 | 12.0-14.0 | 2.0-3.0 | 0.5-2.5 |
| | Si | P | S | Cu | |
| | 0.6 | 0.02 | 0.02 | 0.2 | |
| Specification | 1 max | 0.04 max | 0.03 max | 0.75 max | |

MECHANICAL PROPERTIES OF ALL WELD METAL :

| | Condition | UTS, MPa | EL% |
|---------------|------------------|-----------------|------------|
| Typical | As Welded | 600 | 37 |
| Specification | | 520 | 30 min |

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 |