



BETANOX ZF

STAINLESS STEEL (Austenitic Steel)



Rutile type stainless steel Electrode for urea reactors

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

IS 5206

E 19 12 3 L R 12

E 316L-16

E 19.12.2 LR26

KEY FEATURES :

- Rutile type coating
- Extra low carbon 18/14/Mo type deposit provide resistance to intergranular corrosion
- Nearly zero ferrite content
- Excellent corrosion resistance at high temperature service
- Smooth operating characteristics
- All position capability
- Radiographic quality weld

WELDING POSITION :



AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Specially designed for Urea reactors and Chemical industries
- Welding of Mo bearing austenitic alloys such as AISI 316, 316L, 317, 317L, 318 types
- Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
Typical	0.03	2.1	0.3	18.7	13.1	2.4	0.01	0.01	-
Specification	0.04 max.	0.5-2.5	1 max	18.0-21.0	9.0-11.0	0.75 max	0.03 max	0.04 max	0.75 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	605	37	0.2
Specification		490	30 min	0.5 max

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