



BETANOX 20/25/5/Cu

STAINLESS STEEL (Heat Resisting)



High alloyed stainless steel Electrode with superior corrosion resistance properties

CLASSIFICATION : EN 1600

AWS A/SFA 5.4

IS 5206

E 20 25 5 Cu N L R 12

E 385-16

E 20.25.5 LCu R 26

KEY FEATURES :

- Rutile based semi basic coating
- Low carbon 20/25/5/Cu type fully austenitic deposit
- Recommended for highly corrosive conditions in the chemical industries, sea water desalination plants
- Resistant to pitting and crevice corrosion in chloride bearing media
- Radiographic quality weld deposit
- Resist intergranular corrosion and sulfide stress corrosion cracking
- Scaling resistance upto 1200°C and operating temperatures upto 400°C
- Smooth arc and medium penetration
- Least spatter and easy slag removal
- Finely rippled smooth bead

WELDING POSITION :



AC (70 OCV) / DCEP

TYPICAL APPLICATIONS :

- Welding of 904L, HV-9A, HV-9 stainless steel and similar alloys for high temperature and/or high corrosion service
- Welding of 904L steel to other grades of stainless steel
- Welding of austenitic stainless steels with enhanced corrosion resistance to reducing media
- Suitable for materials 1.4539, 1.4439, 1.4537, 1.4505, 1.4506, 1.4531, 1.4536, 1.4573, 1.4585, 1.4586

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni
Typical	0.02	1.5	0.4	20.4	25.2
Specification	0.03 max	1.0-2.5	0.9 max	19.5-21.5	24.0-26.0
	Mo	Cu	S	P	
Typical	4.7	1.6	0.01	0.01	
Specification	4.2-5.2	1.2-2.0	0.02 max	0.02 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	575	37
Specification		540-600	30-50

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-70	2	5	10
2.5 x 350	70-100	2	5	10
3.15 x 350	90-130	2	5	10
4.0 x 350	140-180	2	5	10

