



BETANOX 20/30

STAINLESS STEEL (Heat Resisting)



High alloyed stainless steel Electrode for elevated temperature application

CLASSIFICATION : AWS A/SFA 5.4

E 320-15

KEY FEATURES :

- Basic coated electrode
- 20/33/2/CuNb stabilized fully austenitic weld
- High strength and excellent oxidation resistance upto 1200°C
- Resistance to corrosion in sulphuric acid, mineral and organic acids
- Smooth and uniform weld beads
- Low spatter loss
- Radiographic quality weld

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Welding AISI 310 type, HV-9A stainless steel, Carpenter 20Cb-3, Alloy 20
- Repairing of castings of similar composition
- For chemical industries handling sulphuric acids and their salts

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni
Typical	0.05	1.7	0.5	20.2	33.7
Specification	0.07 max	1.0-2.5	0.9 max	19.0-21.0	32.0-36.0
	Mo	Cu	Nb	S	P
Typical	2.4	3.4	0.6	0.02	0.02
Specification	2.0-3.0	3.0-4.0	8xC-1.0	0.03 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	620	36
Specification		560-670	30-40

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