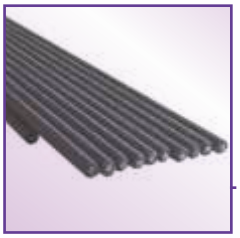

BETANOX 310 PLUS

STAINLESS STEEL (Heat Resisting)

Stainless steel Electrode resistant to high temperature oxidation

CLASSIFICATION : EN 1600	AWS A/SFA 5.4	IS 5206
E 25 20 R 13	E 310-17	E 25.20 R36X

KEY FEATURES :

- Acid-Rutile based coating
- 25/20 SS type deposit
- Provides excellent stability and high temperature oxidation resistance upto 1150°C
- Excellent resistance to cracking & fissuring
- Stable arc and low spatter loss
- Easy slag removal
- Radiographic quality weld

WELDING POSITION :

AC (70 OCV) /DCEP

TYPICAL APPLICATIONS :

- Joining difficult to weld steels such as armor plates and ferritic stainless steels as well as dissimilar steels
- Furnace parts, Annealing boxes and carburizing pots, Gas turbine combustion chamber parts, hydrogenation and polymerization plant
- Welding of AISI 310 and similar grades
- Cladding side of stainless steels and dissimilar steels
- Suitable for materials 1.4710, 1.4713, 1.4745, 1.4762, 1.4823, 1.4832, 1.4837, 1.4840, 1.4841, 1.4845, 1.4846, 1.4848, 1.4849

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	S	P
Typical	0.1	1.7	0.6	26.7	21.4	0.02	0.02
Specification	0.08-0.15	1.0-2.5	0.75 max	25.0-28.0	20.0-22.5	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	610	37
Specification		550-650	30 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 350	50-75	2	5	10
3.15 x 350	80-100	2	5	10
4.0 x 350	110-140	2	5	10