



Betanox DCb

STAINLESS STEEL (Dissimilar Steel Welding)

A Stainless steel Electrode depositing 23/12/Nb alloy

CLASSIFICATION :	EN 1600	AWS A/SFA 5.4	IS 5206
	E 23 12 Nb R 12	E 309 Nb-16	E 23.12 Nb R26

KEY FEATURES :

- Rutile coated electrode
- Deposit is 23/12/Nb stabilized
- Low dilution on mild and low alloy steels due to higher alloy content
- Intergranular corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic weld quality

WELDING POSITION : AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of AISI 309, 309 Nb stabilized steels
- Dissimilar joints between 347 type and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels
- Joining corrosion resistant clad steels

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Nb	Cu	S	P
Typical	0.05	1.4	0.5	23.3	13.0	0.8	0.2	0.02	0.02
Specification	0.10 max	1.0-2.5	0.90 max	22.0-25.0	12.0-14.0	0.7-1.0	0.5 max	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	600	36
Specification		560-660	30-40

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 300	50-75	2	5	10
3.15 x 300	80-100	2	5	10
4.0 x 300	110-140	2	5	10
5.0 x 300	150-180	2	5	10