



Betanox K Spl

STAINLESS STEEL (Austenitic Steel)

Special Electrode for urea reactors and chemical industries

KEY FEATURES :

- Rutile coated electrode
- Extra low carbon 17/13/5Mn/Mo type fully austenitic weld deposit
- Nearly zero ferrite content
- Excellent corrosion resistance at high temperature service
- Smooth operating characteristics
- 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 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P
Specification	0.04 max	5.0-7.0	0.30-0.80	17.0-18.5	11.0-14.0	2.0-3.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Specification	As Welded	550-650	35-45	0.5 max

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

Special batches with modified chemistry to suit customer specifications are available.