



## BETANOX 308 PLUS

STAINLESS STEEL (Austenitic Steel)



Stainless steel Electrode for joining 304 type steels

**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

**IS 5206**

E 19 9 R 13

E 308-17

E 19.9 R36

### KEY FEATURES :

- Acid-Rutile based coating
- 19/10 type austenitic SS weld
- Controlled ferrite content
- Resistant to cracking, atmospheric corrosion and scaling upto 800°C
- Exhibits excellent creep strength

### WELDING POSITION :



**AC (70 OCV) /DCEP**

### TYPICAL APPLICATIONS :

- Welding Cr-Ni steels represented by AISI 301, 302, 304 and 308
- Fabrication of boilers, reactors and turbines
- SS piping in refineries, oil and gas industries, chemical plants
- Build up application on SS surfaces of centrifugal pump impellers and shafts valve faces, seats etc.
- Suitable for material no. 1.4300, 1.4301, 1.4310, 1.4312, 1.4550, 1.4001, 1.4016, 1.4057

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

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>Mn</b>
Specification	0.08 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	<b>Si</b>	<b>P</b>	<b>S</b>	<b>Cu</b>	
Specification	1 max	0.04 max	0.03 max	0.75 max	

### MECHANICAL PROPERTIES OF ALL WELD METAL :

	<b>Condition</b>	<b>UTS, MPa</b>	<b>EL%</b>	<b>Ferrite No.</b>
Typical	As Welded	605	38	4
Specification		550 min	30 min	3-7

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.0 x 300	50-75	2	5	10
2.5 x 350	60-100	2	5	10
3.15 x 350	100-140	2	5	10
4.0 x 350	150-180	2	5	10