

BETANOX 308L PLUS

AWS A/SFA 5.4 E308L-17

STAINLESS STEEL (Austenitic Steel)

CLASSIFICATION:

ISO 3581-A
E 19 9L R 13

IS 5206
E 19.9 LR36

KEY FEATURES:

- Acid-Rutile based coating
- Extra low carbon 19/10 type austenitic weld deposit
- Excellent corrosion and scaling resistance upto 800°C
- Resistant to cracking
- Easy slag removal
- Radiographic quality weld

APPROVALS: - CE

TYPICAL APPLICATIONS:

- Welding Cr-Ni steels such as AISI 301,302, 304, 304L, 308, 308L
- Fabrication of boilers, reactors and turbines
- Build up application on SS
- SS piping in refineries, oil and gas industries, chemical plants
- Suitable for material no. 1.4300, 1.4301, 1.4310, 1.4312, 1.4550, 1.4001, 1.4016, 1.4057

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni
0.02	0.7	0.6	20.5	8.7

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	580	37	6
Specification		520 min	30 min	3-8

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	50-75	 AC (70 OCV) /DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	Flat butt and fillet welds only 
2.5 x 350	80-100		
3.15 x 350	100-140		
4.0 x 350	150-180		

Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each. Also available in vacuum packing

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 308L	Tiginox 308L	Miginox FC 308L	Automelt S33	Subinox 308L