

BETANOX 316 PLUS

AWS A/SFA 5.4 E316-17

STAINLESS STEEL (Austenitic Steel)

CLASSIFICATION:

ISO 3581-A
E 19 12 3 L R 13

IS 5206
E 19.12.2 LR36

KEY FEATURES:

- Acid-Rutile based coating
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Resistant to variety of acids e.g. Sulphuric, Hydrochloric, Acetic, Phosphoric, Citric, Tartaric etc.
- Easy slag removal
- Controlled ferrite content of 4-8 for maximum cracking resistance
- 19/10/2 Mo type SS electrode
- Radiographic quality weld deposit
- Excellent slag removal

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding Mo bearing austenitic alloys such as AISI 316, 316L, 317
- Suitable for material no. 1.4401 and similar grades
- Welding of equipments in Chemical, Paper and pulp, Paint and dye industries

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.02	1.0	19.3	11.35	13.1	2.3

MECHANICAL PROPERTIES OF ALL WELD METAL:


	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	580	36	6
Specification		490 min	30 min	3-8

Hardness, 3 Layer: -

Diffusible H2 Content: -

Special Tests: -

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	50-75	 AC (70 OCV) /DCEP	Flat butt and fillet welds only →
2.5 x 350	80-100		
3.15 x 350	110-140		
4.0 x 350	150-180		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

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