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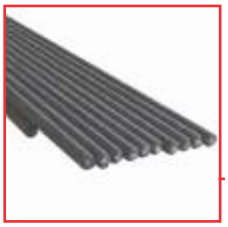

BETANOX 316 PLUS

STAINLESS STEEL (Austenitic Steel)

19/10/2 Mo type stainless steel Electrode for pitting resistance

CLASSIFICATION : ISO 3581-A	AWS A/SFA 5.4	IS 5206
E 19 12 2 R 13	E 316-17	E 19.12.2 R36

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.
- Controlled ferrite content of 4-8 for maximum cracking resistance
- 19/10/2 Mo type SS electrode
- Radiographic quality weld deposit
- Excellent slag removal

WELDING POSITION :

AC (70 OCV) /DCEP

TYPICAL APPLICATIONS :

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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Cr	Ni	Mo	Mn
	0.04	18.7	12.3	2.4	1.2
Specification	0.04 max	18.0-21.0	9.0-11.0	0.75 max	0.5-2.5
	Si	**P**	**S**	**Cu**	
	0.5	0.02	0.02	-	
Specification	1 max	0.04 max	0.03 max	0.75 max	

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%	Ferrite No.
Typical	As Welded	590	36	5
Specification		520	30 min	4-8

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-75	2	5	10
2.5 x 350	80-100	2	5	10
3.15 x 350	110-140	2	5	10
4.0 x 350	150-180	2	5	10