



## BETANOX 316L PLUS

STAINLESS STEEL (Austenitic Steel)



Low carbon stainless steel Electrode for high pitting resistance

**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

**IS 5206**

E 19 12 3 L R 13

E 316L-17

E 19.12.2 LR36

### KEY FEATURES :

- Acid-Rutile based coating
- Extra low carbon 18/13/2.5Mo type weld deposit
- Offers improved corrosion and pitting resistance in marine and industrial environment
- Easy slag removal
- Resist Stress Corrosion Cracking, Hot cracking, Chemical corrosion at high temperature
- Smooth arc characteristics
- Radiographic quality weld deposit

### WELDING POSITION :



**AC (70 OCV) /DCEP**

### 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

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

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

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>S</b>	<b>P</b>	<b>Cu</b>
Typical	0.02	1.3	0.7	18.2	12.5	2.5	0.02	0.02	-
Specification	0.04 max.	0.5-2.5	1 max	18.0-21.0	9.0-11.0	0.75 max	0.03 max	0.04 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	580	36	6
Specification		490	30 min	3-8

### 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	80-100	2	5	10
3.15 x 350	110-140	2	5	10
4.0 x 350	150-180	2	5	10

**EQUIVALENT : GMAW wire: Miginox 316L GTAW filler: Tiginox 316L FCAW wire: Miginox FC 316L**