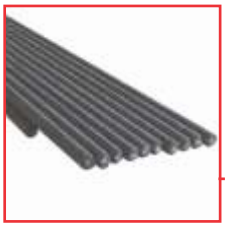

BETANOX K

STAINLESS STEEL (Austenitic Steel)

Basic type stainless steel electrode for urea reactors and chemical industries

CLASSIFICATION :	ISO 3581-A	AWS A/SFA 5.4	IS 5206
	E 19 12 3 L B 22	E 316L-15	E 19.12.2 LB20

KEY FEATURES :

- Basic type coating
- Extra low carbon 17/13/Mo type deposit provide resistance to intergranular corrosion
- Low ferrite content
- Excellent corrosion resistance at high temperature service
- Smooth arc characteristics
- Suitable for all position
- Radiographic quality weld

WELDING POSITION : 

DCEP

TYPICAL APPLICATIONS :

- Specially designed for Urea reactors and Chemical industries
- Welding of Mo bearing austenitic alloys such as AISI 316, 316L, 317, 317L, 318 types
- Suitable for material no. 1.4401, 1.4404, 1.4406, 1.4408, 1.4429, 1.4435, 1.4436, 1.4437, 1.4571, 1.4580, 1.4583

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
Typical	0.03	2.0	0.3	17.9	13.4	2.5	0.01	0.01	-
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 :

	Condition	UTS, MPa	EL%	CVN Impact at -196°C, J	Ferrite No.
Typical	As Welded	580	36	45	1
Specification		490	30 min	27 min.	2 max

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