



# BETANOX DMO

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E309Mo-16**

### CLASSIFICATION:

ISO 3581-B  
ES 309Mo-16

IS 5206  
E 23.12.2 R36

### KEY FEATURES:

- Rutile coated electrode
- High ferrite content ensures maximum cracking resistance
- Mo addition provides high strength and corrosion resistance
- Deposit is 23/12/2.5Mo type
- Excellent corrosion and oxidation resistance upto 1100°C
- Suitable for all position
- Radiographic quality welds

**APPROVALS:** CE

### TYPICAL APPLICATIONS:

- Welding of AISI 309Mo type steels
- Dissimilar joints between 316 type and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels before deposition of 316 type weld metal



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

C	Mn	Si	Cr	Mo	Ni
0.05	1.2	0.5	23.5	2.2	12.7

### MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	650	36
Specification		550 min	30 min

### PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 <b>AC (70 OCV) /DCEP</b> <b>REDRYING CONDITION:</b> 250-300°C for minimum 1 hr.	All Positions, except vertical Down 
3.15 x 350	80-100		
4.0 x 350	110-140		

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