



BETANOX 20/30

STAINLESS STEEL (Heat Resisting)

AWS A/SFA 5.4 **E320-15**

CLASSIFICATION:

ISO 3581-B
ES320-15

KEY FEATURES:

- Basic coated electrode
- 20/33/2/CuNb stabilized fully austenitic weld
- High strength and excellent oxidation resistance upto 1200°C
- Low spatter loss
- Resistance to corrosion in sulphuric acid, mineral and organic acids
- Smooth and uniform weld beads
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding AISI 310 type, HV-9A stainless steel, Carpenter 20Cb-3, Alloy 20
- Repairing of castings of similar composition
- For chemical industries handling sulphuric acids and their salts


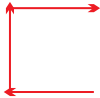
TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

| C | Mn | Si | Cr | Ni | Mo | Nb | Cu |
|------|-----|------|------|------|-----|------|-----|
| 0.04 | 1.2 | 0.55 | 19.3 | 32.5 | 2.3 | 0.45 | 3.6 |

MECHANICAL PROPERTIES OF ALL WELD METAL:

| | Condition | UTS, MPa | EL% |
|---------------|-----------|----------|--------|
| Typical | As Welded | 620 | 36 |
| Specification | | 550 min | 30 min |

PARAMETERS - PACKING DATA:

| Ø x L, mm | Amperage, A | | |
|------------|-------------|--|--|
| 2.5 x 350 | 50-75 |  DCEP REDRYING CONDITION: 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.