



BETANOX 309Cb PLUS

STAINLESS STEEL (Dissimilar Steel Welding)

AWS A/SFA 5.4 **E309Nb-17**

CLASSIFICATION:

ISO 3581-A

E 23 12 Nb R 13

IS 5206

E 23.12 Nb R36

KEY FEATURES:

- Acid-Rutile based coating
- 23/12/Nb stabilized SS deposit
- Resistant to cracking
- Low dilution on mild and low alloy steels due to higher alloy content
- Resist intergranular corrosion
- Superior strength and oxidation resistance upto 1100°C
- Easy slag removal
- Radiographic quality weld deposit

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of AISI 309, 309 Nb type steels
- Dissimilar joints between 347 type and low alloy or carbon steels
- Buffer layer on low alloy and carbon steels before deposition of 18/8 type stabilized weld metal
- Joining corrosion resistant clad steels



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Nb
0.05	1.0	0.9	23.1	12.2	0.75

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	As Welded	620	35
Specification		550 min	30 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.5 x 350	50-75	 AC (70 OCV) /DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	Flat butt and fillet welds only 
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.