

# BETANOX K

AWS A/SFA 5.4 E316L-15

STAINLESS STEEL (Austenitic Steel)

## CLASSIFICATION:

ISO 3581-A  
E (19 12 3 L) B 22

IS 5206  
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
- All position capability
- Excellent corrosion resistance at high temperature service
- Smooth arc characteristics
- Suitable for all position
- Radiographic quality weld

**APPROVALS:** CE

## 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

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

C	Mn	Si	Cr	Ni	Mo
0.025	2.1	0.4	18	13.1	2.2



## 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 min	30 min	27 min	2 max

Special Tests: IGC Practice E of ASTM A262

Typical lateral expansion: 0.50 min

## PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	50-75	 AC (70 OCV) /DCEP	All Positions, except vertical Downwards
2.5 x 350	80-100		
3.15 x 350	110-140		
4.0 x 350	150-180		
		REDRYING CONDITION: 250-300°C for minimum 1 hr.	

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