

BETANOX -C

CLASSIFICATIONS

AWS A/SFA 5.4 E310-16
IS 5206 E 25.20 R26X

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode to deposit 25/20 SS which has excellent stability and oxidation resistance in continuous service upto 1150°C. The weld metal is of radiographic quality. Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

TYPICAL APPLICATIONS

Welding AISI 310 type, German Steels 4762, 4828, 4841, 4846 and 4848, cladding side of stainless clad steels, straight chrome steels and dissimilar steels, hydrogenation and polymerisation plant, gas turbine combustion chamber parts, high temperature furnace parts, annealing boxes and carburizing pots.

WELD METAL CHEMISTRY, (%)

C - 0.08-0.12	S - 0.03 max.	Cr - 25.0-28.0
Mn - 1.0-2.5	P - 0.03 max.	
Si - 0.30-0.70	Ni - 20.0-22.5	

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd) 30min.
As-welded	560-660	

APPROVALS

BPCL E 310-16
KRL E 310-16

CURRENT CONDITIONS: AC, DC (+)

5.0	4.0	3.2	2.5
150-180	110-140	80-100	50-75

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour
(Optionally also available in vacuum-packed condition.)

PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	300	300	300	300
Wt. per carton, kg	2	2	2	2
Cartons / box	5	5	5	5
Net wt per box, kg	10	10	10	10



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

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