

BETANOX D

CLASSIFICATIONS

AWS A/SFA 5.4 E309-16
IS 5206 E 23.12 R26

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode to deposit 25/12 SS which has excellent corrosion and oxidation resistance in continuous service upto 1100°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 of AISI 309 type, Joining SS to Low alloy steels or Carbon steels. Deposition of buffer layer on Carbon steel or low alloy steels before deposition of 18/8 type of weld metal.

APPROVALS

BPCL E 309-16 **TOYO**
KPG E 309-16 **IBR** E 309-16
BHEL E 309-16

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.)

WELD METAL CHEMISTRY, (%)

C - 0.10 max.	S - 0.03 max.	Cr - 22.0-25.0
Mn - 1.0-2.5	P - 0.03 max.	
Si - 0.90 Max	Ni - 12.0-14.0	

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

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite No.
As-welded	560-660	30-45	12-15



WELDERS TO THE NATION SINCE 1951
ADOR WELDING LIMITED

(Formerly Known as Advani-Oerlikon Ltd.)

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