

BETANOX K

CLASSIFICATIONS

AWS A/SFA 5.4 E316L-15
IS 5206 E 19.12.2LB20

IDENTIFICATION: Name Printed

CHARACTERISTICS

An electrode to deposit extra low Carbon 17/13/2.5Mo SS which has excellent corrosion resistance at high temperature service. 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 316/316L/317L type SS; Specially designed for Urea reactors and chemical industries.

WELD METAL CHEMISTRY, (%)

C - 0.04 max.	S - 0.03 max.	Cr - 17.0-20.0
Mn - 1.0-2.5	P - 0.03 max.	Mo - 2.0-3.0
Si - 0.20-0.45	Ni - 12.0-14.0	

MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	% Elong. (L=4Xd)	Ferrite, FN
As-welded	530-630	32-42	<2

CURRENT CONDITIONS: DC(+)

5.0	4.0	3.2	2.5
150-180	110-140	80-100	50-90

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

(Formerly Known as Advani-Oerlikon Ltd.)

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