



Betanox DMoL

STAINLESS STEEL (Dissimilar Steel Welding)

Extra low carbon stainless steel Electrode depositing 23/12/2.5Mo alloy

CLASSIFICATION : EN 1600 AWS A/SFA 5.4 IS 5206
 E 23 12 2 L R 12 E 309LMo-16 E 23.12.2 LR26

KEY FEATURES :

- Rutile coated electrode
- Extra low carbon 23/12/2.5Mo type weld deposit
- Low carbon ensures resistance to intergranular corrosion and cracking
- Mo addition provides high strength
- Excellent corrosion and oxidation resistance at elevated temperatures
- All position capability
- Radiographic quality welds

WELDING POSITION : AC (70 OCV)/DCEP

TYPICAL APPLICATIONS :

- Welding of AISI 316, 316L type steels
- Buffer layer on low alloy and carbon steels to improve corrosion and wear resistance
- Joining difficult to weld steels
- Dissimilar joints between austenitic stainless steels containing Mo and low alloy or carbon steels

REDRYING CONDITION : 300°C for 1 hr. (Also available in vacuum packed condition)

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P
Typical	0.03	1.6	0.6	23.2	12.7	2.5	0.02	0.02
Specification	0.04 max	1.0-2.5	0.3-0.7	22.0-25.0	12.0-14.0	2.0-3.0	0.03 max	0.03 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	EL%
Typical	As Welded	600	37
Specification		520 min.	30 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.5 x 300	50-75	2	5	10
3.15 x 300	80-100	2	5	10
4.0 x 300	110-140	2	5	10
5.0 x 300	150-180	2	5	10