

## BATOX-F(U)

**CODIFICATION:** AWS : SFA 5.4 E316L-16 (Modified)

### CHARACTERISTICS AND APPLICATIONS:

Batox-F(U) is a semi-basic coated electrode depositing a weld metal which is fully austenitic in structure, has high strength and good crack resistance. The weld metal displays remarkable corrosion resistance particularly in urea service. Ideally suitable for welding of AISI 316L and their nitrogen bearing versions particularly for urea service.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	Cr	Ni	N	Mo	S	P
Percent	: 0.03	4.0	0.45	19.5	16.0	0.15	2.8	0.015	0.020

**FERRITE CONTENT** : Nil

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L= 4d)%	Corrosion Rate (ASTM A262 Practice C)
634	37.0	7 mils/year

### CURRENT AND PACKING DATA: DC(+)

Size (mm)	: 5x350	4x350	3.15x350	2.5x350
Dia x Length				
Current Range (Amps)	: 150-180	110-140	80-100	60-80
Weight/Carton (kgs)	: 2.5	2.5	2.5	2.5

### PRECAUTIONS:

1. The electrode should be dry. In case of moisture pick-up, redry the electrodes at 250-300°C for one hour.
2. Use short arc, stringer bead, smallest size of electrode and minimum current to ensure minimum heat input.