



BATOX-F(U)M

CODIFICATION: AWS : SFA 5.4 E316LMn-15

CHARACTERISTICS AND APPLICATIONS :

Batox-F(U)M is a basic coated electrode depositing fully austenitic stainless steel weld metal. The deposit possesses excellent crack resistance and is suitable for welding for high pressure parts of urea plant equipment to resist severe corrosion. It is ideally suited for welding of stainless steels of similar composition and their equivalents for overlays, surfacing applications, etc.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P	Cr	Ni	Mo	N
Percent	: 0.035	5.50	0.45	0.015	0.025	18.8	16.5	3.00	0.11

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L= 4d)%
620	30.0

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/Cartron (kgs)	:	2.5	2.5	2.5	2.5

PRECAUTIONS :

1. Re-dry the electrodes at 250-300°C for one hour for best results.
2. Use low current, short arc and stringer bead.