



BATOX-330H

CODIFICATION:	AWS :	SFA 5.4	E330H-15
	EN ISO :	3581-B	ES 330H-15

CHARACTERISTICS AND APPLICATIONS:

Batox-330H is a basic stainless steel electrode depositing a weld metal containing 0.40C - 16Cr - 35Ni. These electrodes are used primarily for the welding and repairing of high alloy heat and corrosion resistant castings of the same composition which are designated HT. It can be used up to 1150°C in oxidizing atmosphere and up to 1090°C in reducing atmospheres.

TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	S	P	Cr	Ni
Percent	: 0.40	1.75	0.60	0.020	0.025	16.0	35.0

TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS	Elongation
(MPa)	(L = 5d)%
700	11.0

CURRENT AND PACKING DATA: DC(+)

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

APPROVAL: CE

PRECAUTIONS:

1. Re-dry the electrodes at 250-300°C for one hour, as per our standard recommended practice.
2. Use short arc, stringer bead, smallest size of electrode and minimum current to ensure minimum heat input.