



## BATOX-B

<b>CODIFICATION:</b>	AWS	: SFA 5.4	E308L-15
	IS	: 5206	E 19.9 L B 20

### CHARACTERISTICS AND APPLICATIONS:

Basic coated electrode depositing low carbon 19Cr - 10Ni stainless steel weld metal which has excellent resistance to Intergranular Corrosion. The weld metal has higher resistance to cracking, oxidation, and scaling at elevated temperatures. It is ideally suited for welding of stainless steels of similar composition like 304L and equivalents, for overlays, surfacing, and repairing castings of similar materials.

### TYPICAL CHEMICAL COMPOSITION OF ALL WELD METAL:

Element	: C	Mn	Si	P	S	Cr	Ni
Percent	: 0.03	1.40	0.40	0.020	0.020	19.8	10.0

### TYPICAL MECHANICAL PROPERTIES OF ALL WELD METAL:

UTS (MPa)	Elongation (L = 4d)%	CVN Impact strength at minus 196°C (J)	Lateral Expansion at minus 196°C (mm)
565	40.0	45	0.50

**FERRITE: 3.0 – 6.0 FN**

### 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
Quantity (kgs/Carton)	:	2.5	2.5	2.5	2.5

**APPROVAL: BHEL, NPCIL**

### PRECAUTIONS:

1. Ensure the electrodes are dry. Re-dry the electrodes at 250-300°C for one hour.
2. Use short arc and stringer bead.