



BATOX-310LMoN



Codification :

EN ISO: 3581

E 25 22 2 N L B



Characteristics & Applications :

It is a basic coated type of electrode that produces low carbon, low silicon and high manganese stainless steel weld to ensure free from micro-fissures. It is a fully austenitic stainless steel that does not have intermetallic phases such as intergranular carbide precipitations. The nitrogen in the weld metal helps to stabilize and strengthen the austenitic phase. The weld metal provides improved corrosion-resistance in nitric acid environment and urea carbamate environments such as high-pressure strippers. Typical applications of the welds are in the production and processing of urea and sulphuric acid.

Typical Chemical Composition Of All Weld Metal (%) :

Element	C	Mn	Si	P	S	Cr	Ni	Mo	N	Cu
Typical	0.03	4.0	0.4	0.020	0.005	25.0	22.0	2.20	0.15	0.05

Typical Mechanical Properties Of All Weld Metal :

Properties	UTS(MPa)	%El (L=5d)	CVN Impact Strength (J)	Hardness (BHN)
			-50°C	
Typical	580	32	50	143-160

Corrosion Properties Of All Weld Metal :

Corrosion Rate as per ASTM A262 Practice-C: 22.0 mils/year Max.

Welding Positions :



Current And Packing Data: DC(+)

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

Precautions :

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

