

# BETACHROME 13/4

## CLASSIFICATIONS

**COATING TYPE:** Basic      **IDENTIFICATION:** Brand Printed

## CHARACTERISTICS

A Hydrogen controlled electrode for welding of Martensitic-Ferritic Chromium steels. The weld metal contains 13% Cr-4% Ni. Weld Metal is of radiographic quality Excellent arc stability and low spatter loss. All sizes strike and re-strike easily. The slag is easily controlled and does not interfere with the arc action. Weld beads are smooth, uniform and of excellent appearance.

## TYPICAL APPLICATIONS

Specially suitable for surfacing of steel casting as well as welding of similar composition of steel. For welding of guide vans and runners, similar corrosion resisting Chromium steels and steel castings.

## CURRENT CONDITIONS: DC(+)

5.0	4.0	3.2	2.5
150-	110-	80-	60-
190	160	120	80

## WELDING POSITIONS

F, H, V-up, OH

## WELDING CONDITIONS

300°C for 1 hour

(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

## MECHANICAL PROPERTIES- ALL-WELD

Condition	UTS MPa	YS MPa	% Elong. (L=4xd)
PW-1	850-950	720 min	16 min
PW-2	800-900	600 min	16 min

PW-1: SR at 580°C for 8 Hrs. PW-2: Heat treatment at 1050°C for 4 Hrs. and Tempering at 610°C for 10 Hrs.

## PACKING DATA

Dia., mm	5.0	4.0	3.2	2.5
Length, mm	300	300	300	300
Wt. per carton, Kgs	6	6	6	6
Carton / box	3	3	3	3
Wt, Per Box, kgs	18	18	18	18

## WELD METAL CHEMISTRY, wt%

C - 0.07 max.	S - 0.03 max.	Cr - 12.0-14.0
Mn - 0.30 - 0.90	P - 0.03 max.	Mo - 0.40-0.65
Si - 0.15 - 0.60	Ni - 3.5 - 4.5	



# ADOR WELDING LIMITED

