



BETACHROME 13/4 (LB)

CLASSIFICATIONS

AWS A/SFA 5.4 E 410 Ni Mo-15

CHARACTERISTICS

An medium heavy coated basic type electrode specially developed for welding extra-low carbon grades of casting and forgings having similar chemical composition and surfing applicants. Manipulation and slag removal are very easy. Radiographic results excellent resistance to corrosin, Erosin. Pitting and impact.

WELDING POSITIONS

F, H, V-up, OH

REDRYING CONDITIONS

300°C for 1 hour

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

SPECIAL INSTRUCTION FOR WELDING

Keep electrodes dry. Do not use excessive currents. Hold short arc. Use good fill-up on joints. Adopt Proper Sequence. Remove the slag with a stainless still wire brush. Post weld treatment should not exceed 620°C as higher temperature may result in rehardening due to tempered martensite in the microstructure after cooling to room temperature.

MECHANICAL PROPERTIES- ALL-WELD		
Condition	UTS MPa	% Elong. (L=4Xd)
AW	560-670	30-40

AW : As-welded

WELD METAL CHEMISTRY, wt%		
C - 0.05 max.	Si - 0.20-0.65	S - 0.030 max.
Cu - 0.50 max.	Mo - 0.40-0.70	P - 0.030 max.
Cr - 11.0-12.50	Ni - 4.00-5.00	Mn - 0.25-0.90

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
Cartons/ box	3	3	3	3
Wt. per box, kgs	18	18	18	18