# BETACHROME 13Cr

CLASSIFICATIONS
AWS A/SFA 5.4 E 410-15

COATING TYPE: Basic
COATING FACTOR: Heavy IDENTIFICATION: Brand Printed

CURRENT CONDITIONS: DC (+)

| 5.0 | 4.0 | 3.2 | 2.5 |
|---|---|---|---|
| 170-220 | 130-160 | 80-120 | 50-70 |

CHARACTERISTICS
An electrode for welding of Ferritic Martensitic Chrome steels. The weld metal contains ~13%Cr and is of air-hardenable type. Hardening can be avoided through preheating and stress relieving. 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.

WELDING POSITIONS
F, H, V-up, OH

REDRYING CONDITIONS
300$^0$C for 1 hour
(Optionally also available in vacuum-packed condition, redrying not required in this packaging)

TYPICAL APPLICATIONS
For welding of Ferritic Martensitic Chrome steels and steel castings. Used in general corrosion and heat resisting applications. For cutlery, pump parts, castings, Oil refinery equipments etc.

| MECHANICAL PROPERTIES- ALL-WELD | | |
|---|---|---|
| Condition | UTS MPa | % Elong. (L=4Xd) |
| AW | 460 Min. | 20 min. |

AW : As-welded

| WELD METAL CHEMISTRY, wt% | | |
|---|---|---|
| C - 0.10 max. | S - 0.03 max. | Cr - 11.0-13.50 |
| Mn - 1.0 max. | P - 0.03 max | Cu - 0.50 max. |
| Si - 0.20-0.65 | Ni - 0.7 max. | Mo - 0.50 max. |

| 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 |