

BETACHROME 13/4 LB

AWS A/SFA 5.4 E410NiMo-15

STAINLESS STEEL (Plain Chrome Series)

CLASSIFICATION:

ISO 3581-A
E 13 B 22

IS 5206
E 13.4 B20

KEY FEATURES:

- Basic type non-synthetic electrode
- Medium-heavy coated
- High strength combined with excellent toughness and cracking resistance
- Preheat and PWHT recommended
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact
- Smooth arc characteristics
- Easy slag removal
- All position welding capability
- Radiographic quality weld

APPROVALS: CE

TYPICAL APPLICATIONS:

- Welding of ASTM CA 6NM casting or similar materials as well as light gauge 410, 410S and 405 base metals
- Welding of extra low carbon castings and forgings of similar composition and surfacing applications
- Surfacing of turbine blades, high pressure valves
- Repair of runners, valve seats, pulp and paper plant equipment
- German castings/forgings type G-X5CrNi13.4 and G-5CrNi13.6, VIRGO 104 casting/forging

TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.04	0.8	0.5	11.9	4.6	0.5

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%	CVN Impact at 27°C, J
Typical	PWHT: 607°C for 1 hr	880	18	60
Specification		760 min	15 min	47 min

PARAMETERS - PACKING DATA:

Ø x L, mm 2.0 x 300 2.5 x 350 3.15 x 350 4.0 x 350	Amperage, A 60-80 80-120 110-160 150-190	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
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Available in Standard carton packing of 10 kg box containing 5 cartons of 2 kgs each.

EQUIVALENT:

GMAW	GTAW	FCAW	SAW	
			Flux	Wire
Miginox 410NiMo	Tiginox 410NiMo	Miginox FC 410NiMo	Automelt S33	Subinox 410NiMo