

BETACHROME 13/4 LB-R AWS A/SFA 5.4 E410 NiMo-16

STAINLESS STEEL (Plain Chrome Series)

CLASSIFICATION:

ISO 3581-A
E 13 4 R 12

IS 5206
E 13.4 R26

KEY FEATURES:

- Rutile type electrode
- High strength, toughness and cracking resistance
- Smooth ARC characteristics
- Easy slag removal
- Martensitic type alloy resistant to corrosion, erosion, pitting and impact
- Preheat and PWHT recommended
- 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 GX5CrNi13.4 and G-5CrNi13.6, VIRGO 104 casting/forging



TYPICAL CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt %:

C	Mn	Si	Cr	Ni	Mo
0.05	0.7	0.5	12.3	4.5	0.6

MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Specification	PWHT: 607°C for 1 hr	760 min	15 min

PARAMETERS - PACKING DATA:

Ø x L, mm	Amperage, A		
2.0 x 300	60-80	 DCEP REDRYING CONDITION: 250-300°C for minimum 1 hr.	All Positions, except vertical Downwards 
2.5 x 350	80-120		
3.15 x 350	110-160		
4.0 x 350	150-200		

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