



## BETACHROME 13/4 LB-R

STAINLESS STEEL (Plain Chrome Series)



410NiMo Type Stainless Steel Electrode

**CLASSIFICATION : ISO 3581-A**

**AWS A/SFA 5.4**

E 13 4 R 12

E 410 NiMo-16

### 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

**WELDING POSITION :**



**AC (70 OCV)/DCEP**

### 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

**REDRYING CONDITION : 250-300°C for minimum 1 hr.**

### CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	<b>C</b>	<b>Mn</b>	<b>Si</b>	<b>Cr</b>	<b>Ni</b>	<b>Mo</b>	<b>S</b>	<b>P</b>	<b>Cu</b>
Specification	0.06 max	1.0 max	0.90 max	11.0-12.5	4.0-5.0	0.40-0.70	0.03 max	0.04 max	0.75 max

### MECHANICAL PROPERTIES OF ALL WELD METAL :

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

### PARAMETERS - PACKING DATA :

<b>Ø x L, mm</b>	<b>Amperage, A</b>	<b>Wt./Carton, Kg</b>	<b>Cartons/Box</b>	<b>Net wt./Box, Kg</b>
2.0 x 300	60-80	2	5	10
2.5 x 350	80-120	2	5	10
3.15 x 350	110-160	2	5	10
4.0 x 350	150-200	2	5	10