



BETACHROME 13/4 LB

STAINLESS STEEL (Plain Chrome Series)



Stainless steel Electrode depositing high strength martensitic alloy

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

E 13 B 22

E 410NiMo-15

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

WELDING POSITION :



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 G-X5CrNi13.4 and G-5CrNi13.6, VIRGO 104 casting/forging

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P	Cu
Typical	0.04	0.8	0.5	11.7	4.8	0.5	0.01	0.02	-
Specification	0.06 max	1 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 :

	Condition	UTS, MPa	YS at 0.2% offset, MPa	EL%	CVN Impact at 0°C, J
Typical	PWHT: 607°C	880	725	18	55
Specification	for 1 hr	760 min	600 min	15 min	40 min

PARAMETERS - PACKING DATA :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
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

EQUIVALENT : GMAW wire: Miginox 410NiMo

GTAW filler: Tiginox 410NiMo