



BETACHROME 13/4

STAINLESS STEEL (Plain Chrome Series)



Stainless steel Electrode for surfacing and Welding corrosion resisting Cr steels

CLASSIFICATION : ISO 3581-A

E 13 4 B 22

KEY FEATURES :

- Basic coated synthetic electrode
- Typical 13Cr/4Ni deposit
- Suitable for martensitic-ferritic Cr steels
- Excellent arc characteristics
- Easy slag removal
- Smooth and uniform weld beads
- All position welding capability
- Radiographic quality weld

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- Suitable for surfacing of steel casting
- Welding of similar composition steels
- Guide vanes and runners
- Similar corrosion resisting Cr steels and steel castings

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	S	P
Typical	0.05	0.6	0.4	13.3	3.9	0.5	0.02	0.02
Specification	0.07 max	0.3-0.9	0.15-0.60	12.0-14.0	3.5-4.5	0.40-0.65	0.03 max	0.04 max

MECHANICAL PROPERTIES OF ALL WELD METAL :

	Condition	UTS, MPa	YS, MPa	EL%
Range	PWHT: 580°C for 8 hrs	850-950	720 min	16 min
Range	PWHT: 1050°C for 4 hrs Tempering: 610°C For 10 hrs	800-900	600 min	16 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	150-190	2	5	10