

# BETACHROME 13Cr

AWS A/SFA 5.4 E410-15

STAINLESS STEEL (Plain Chrome Series)

## CLASSIFICATION:

ISO 3581-A  
E 13 B 22

IS 5206  
E 13 B26

## KEY FEATURES:

- Basic coated electrode
- Typical 13Cr martensitic alloy
- Proper preheating and stress relieving required to avoid hardening
- Air hardenable weld deposit
- Stable arc and low spatter loss
- All position capability
- Radiographic quality weld

**APPROVALS:** CE

## TYPICAL APPLICATIONS:

- For welding ferritic martensitic chrome steels and steel castings
- For general corrosion and heat resisting applications
- Cladding of exhaust valvesmufflers, manifolds, manifold elbows
- For cutlery, pump parts, castings, oil refinery equipments
- Suitable for 1.4000, 1.4002, 1.4006, 1.4021, 1.4024 and AISI 410/420 steel



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

C	Mn	Si	Cr
0.07	0.5	0.25	12.2

## MECHANICAL PROPERTIES OF ALL WELD METAL:

	Condition	UTS, MPa	EL%
Typical	PWHT: 745°C for 1 hr	570	27
Specification		520 min	20 min

## PARAMETERS - PACKING DATA:

<b>Ø x L, mm</b> 2.0 x 300 2.5 x 350 3.15 x 350 4.0 x 350	<b>Amperage, A</b> 50-70 80-120 130-160 170-220	 <b>AC (70 OCV)/DCEP</b>  <b>REDRYING CONDITION:</b> 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 410	Tiginox 410	Miginox FC 410	Automelt S33	Subinox 410