



BETACHROME 13Cr

STAINLESS STEEL (Plain Chrome Series)



Martensitic stainless steel Electrode for general corrosion & heat resistance application

CLASSIFICATION : ISO 3581-A

AWS A/SFA 5.4

E 13 B 22

E 410-15

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

WELDING POSITION :



DCEP

TYPICAL APPLICATIONS :

- For welding ferritic martensitic chrome steels and steel castings
- For general corrosion and heat resisting applications
- Cladding of exhaust valves
- 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

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

CHEMICAL COMPOSITION OF UNDILUTED WELD METAL, Wt % :

	C	Mn	Si	Cr	Ni	Mo	Cu	S	P
Typical	0.07	0.6	0.4	12.8	0.3	0.1	0.1	0.02	0.02
Specification	0.12 max	1.0 max	0.90 max	11.0-13.5	0.7 max	0.75 max	0.75 max	0.03 max	0.04 max

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 :

Ø x L, mm	Amperage, A	Wt./Carton, Kg	Cartons/Box	Net wt./Box, Kg
2.0 x 300	50-70	2	5	10
2.5 x 350	80-120	2	5	10
3.15 x 350	130-160	2	5	10
4.0 x 350	170-220	2	5	10